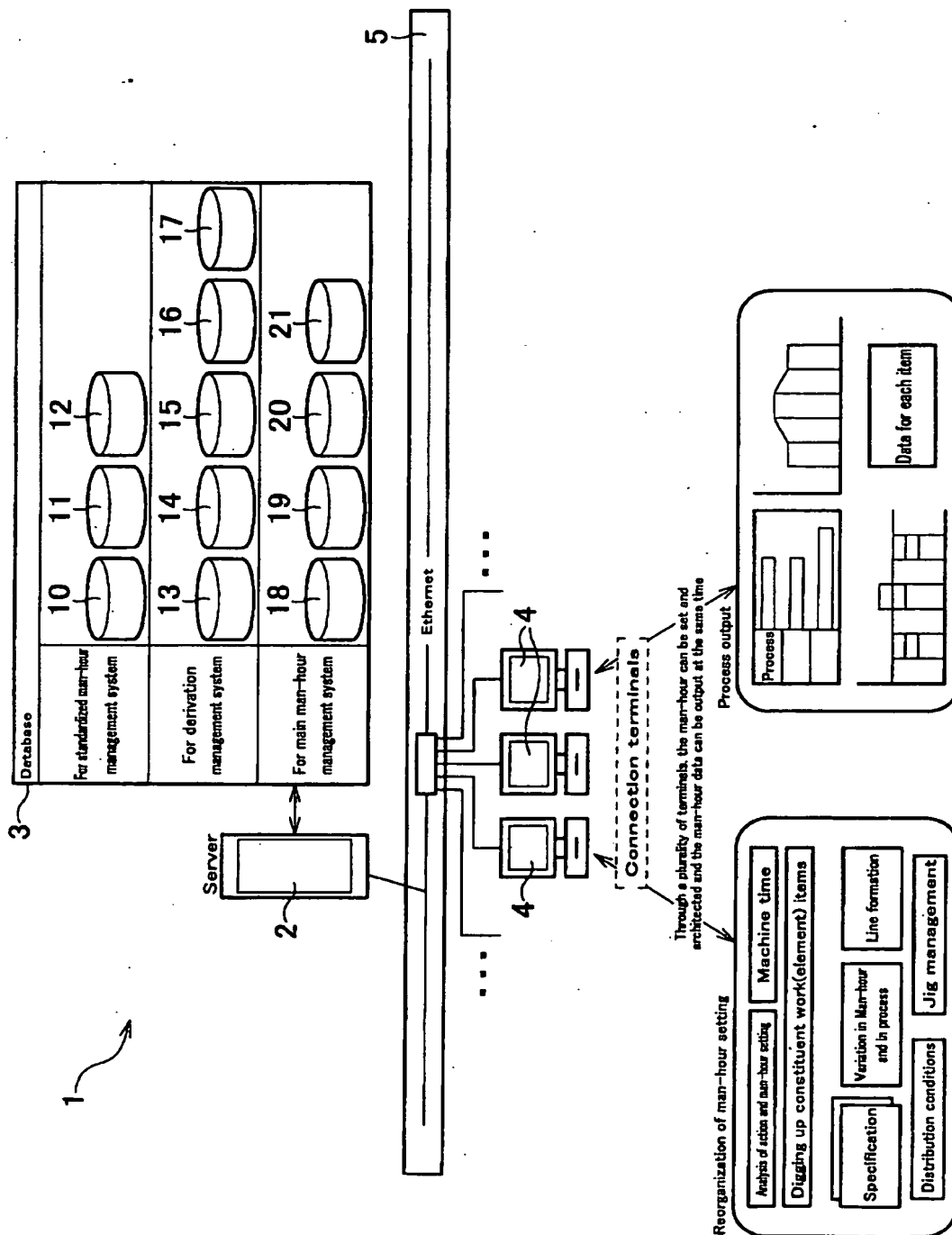


FIG. 1



Y09340 " 2424950

FIG.2

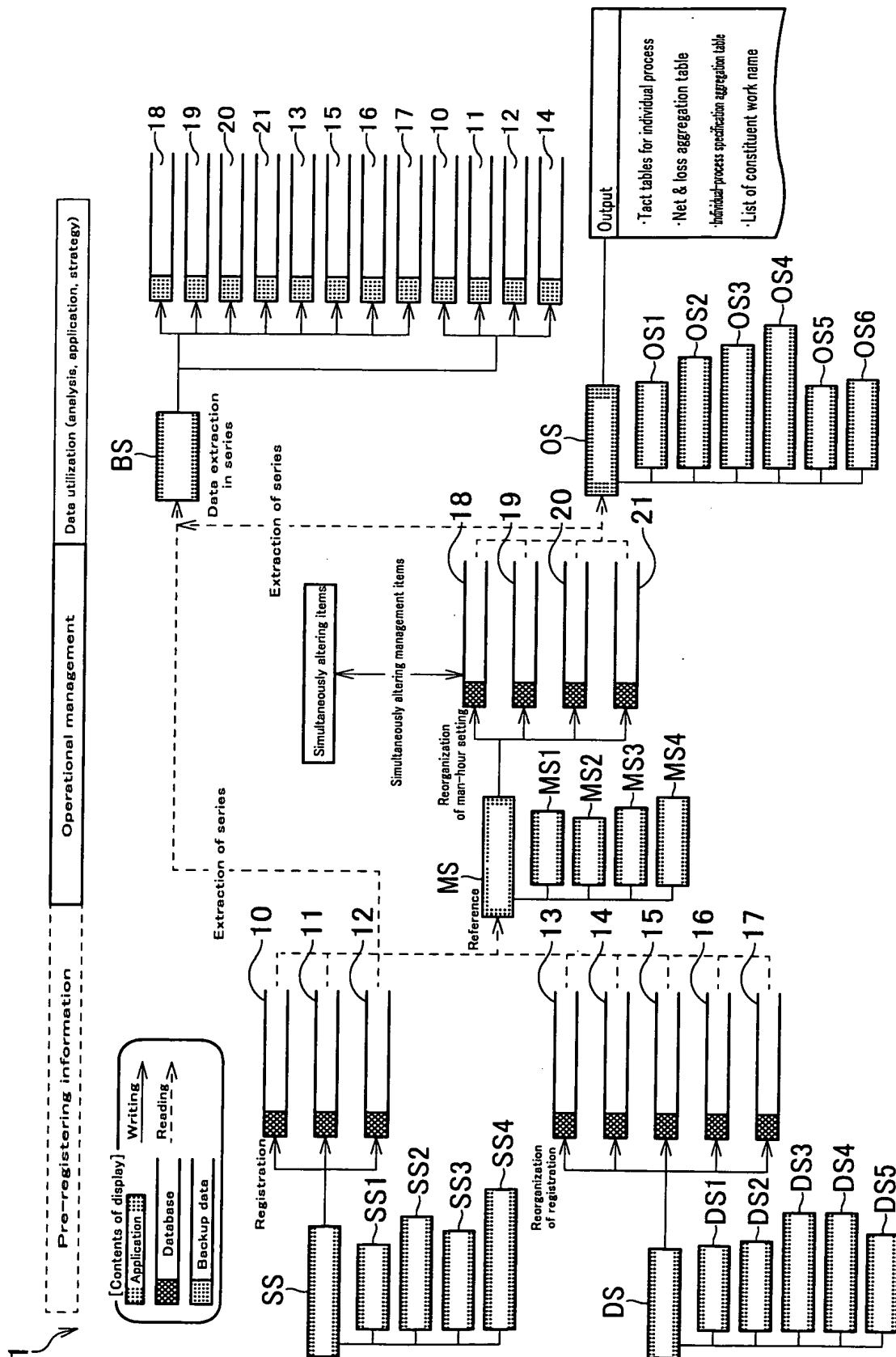




FIG. 4

FIG. 4

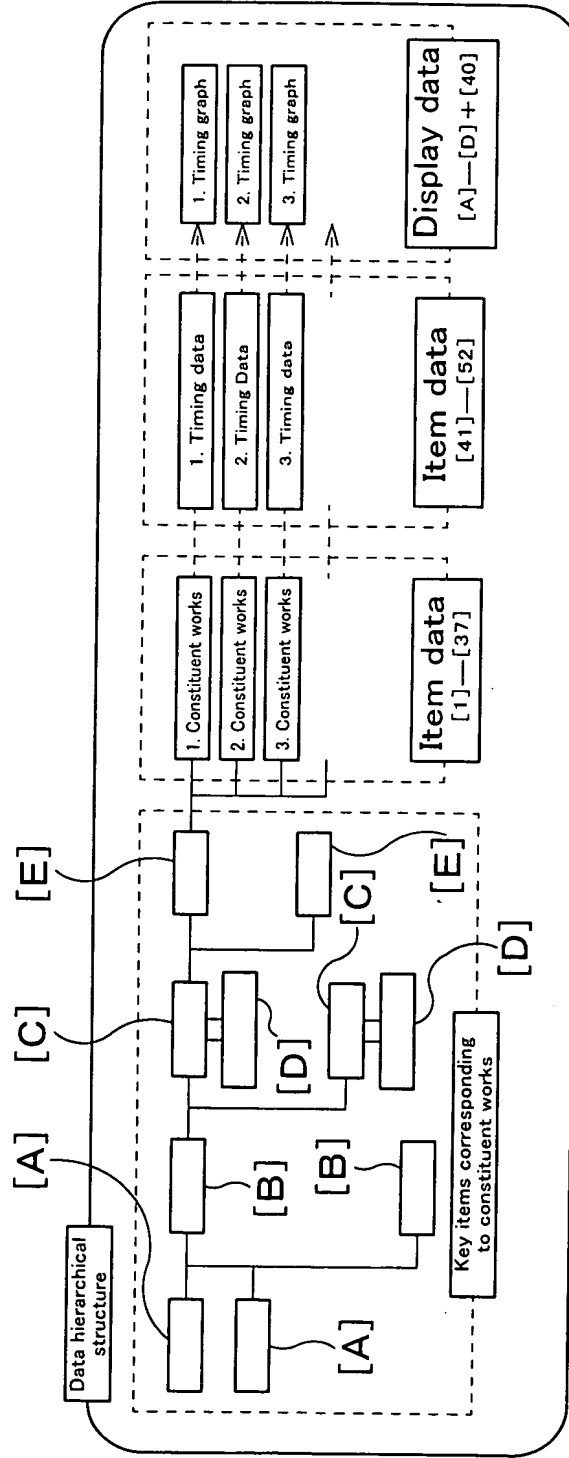
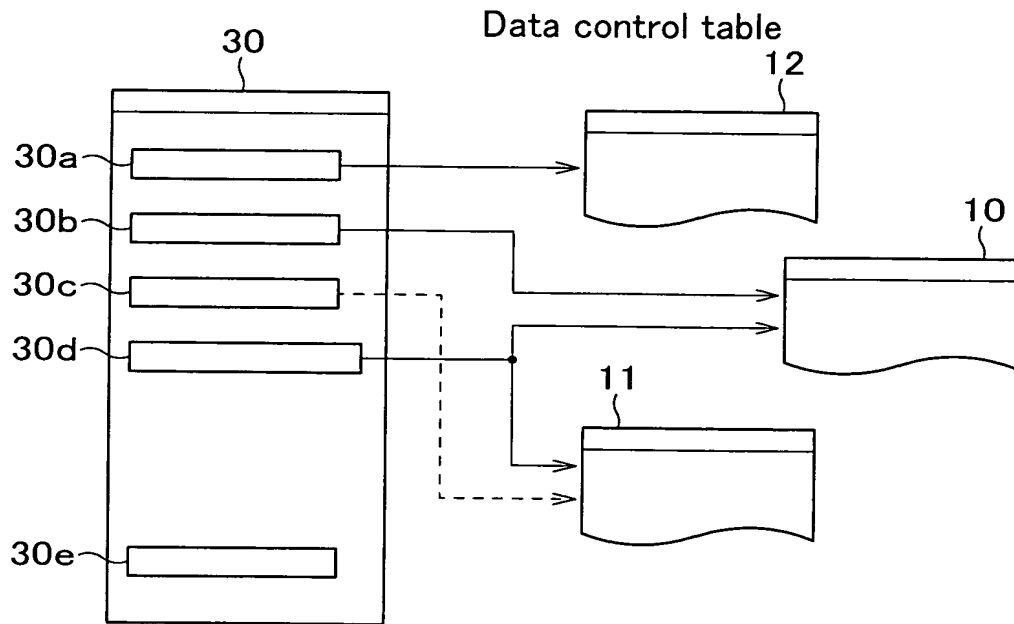
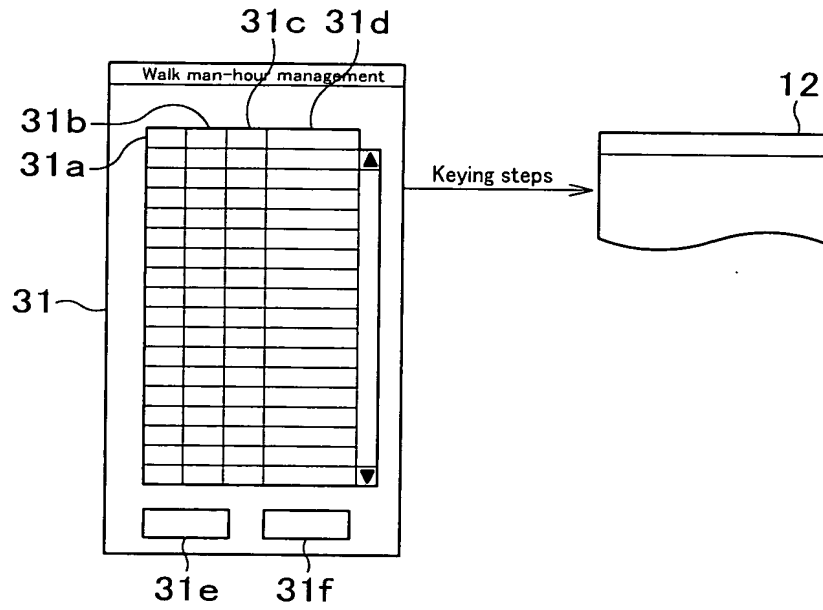


FIG. 5



03443300

FIG. 6



030425.10US01

FIG. 7A

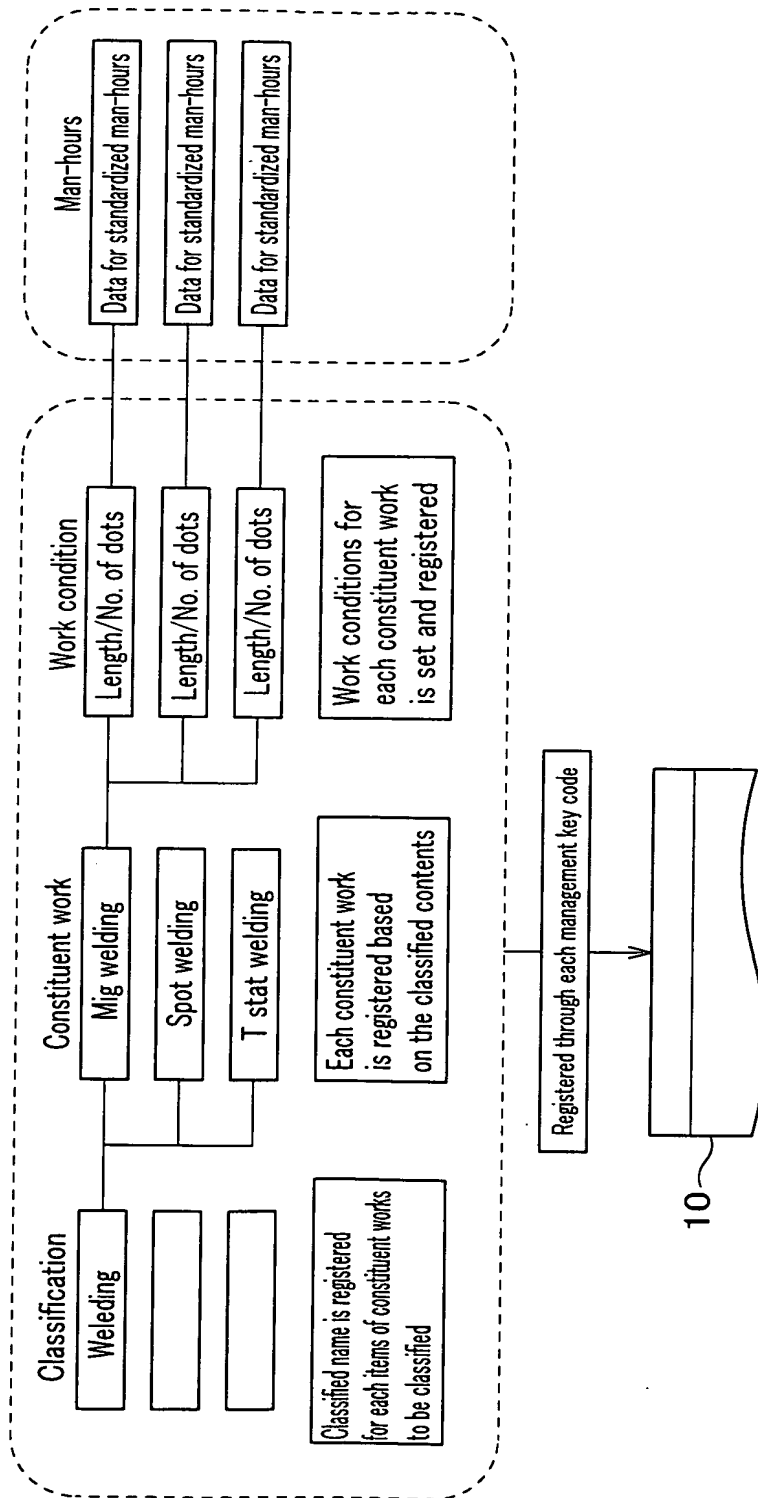


FIG. 7B

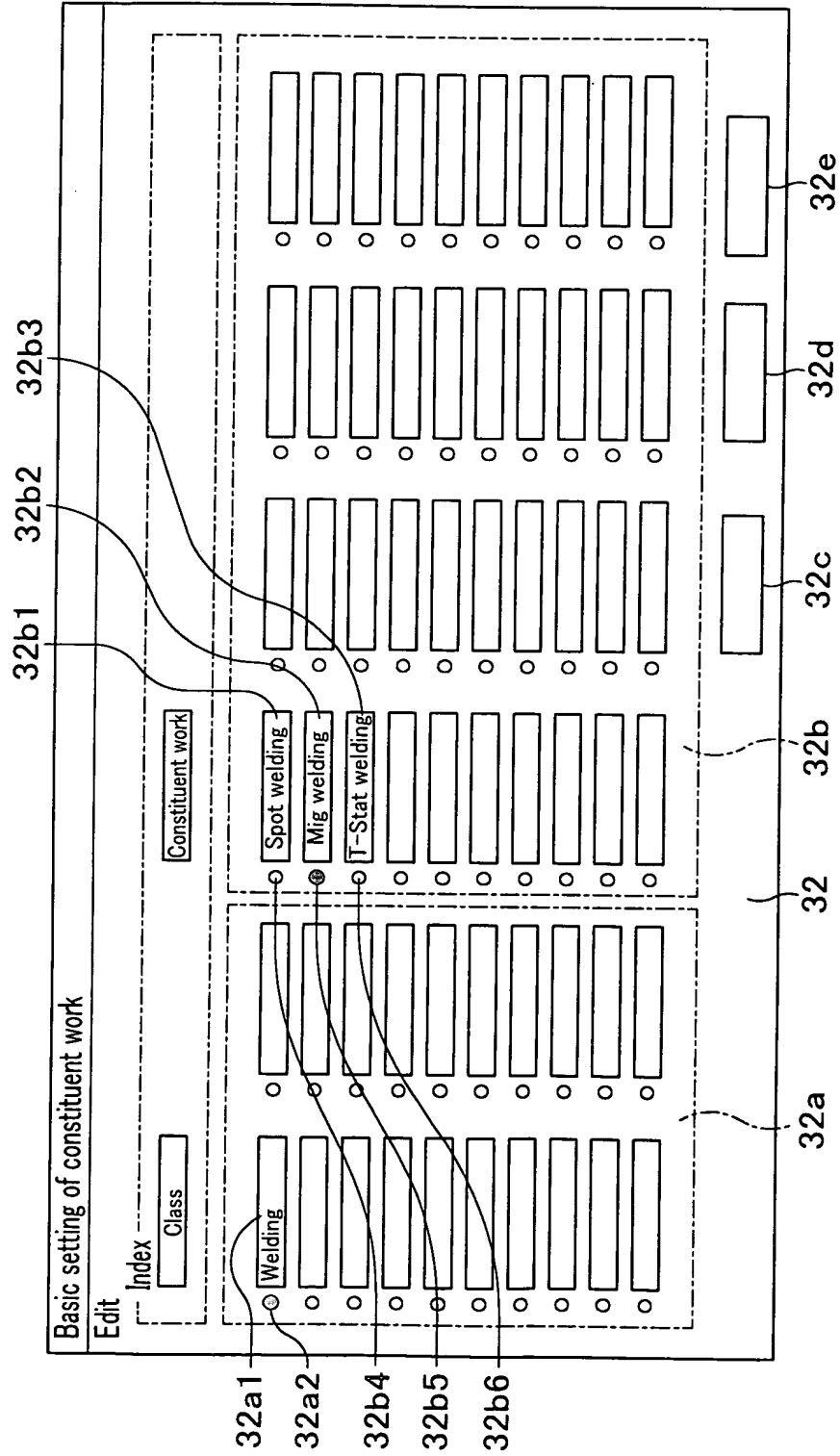
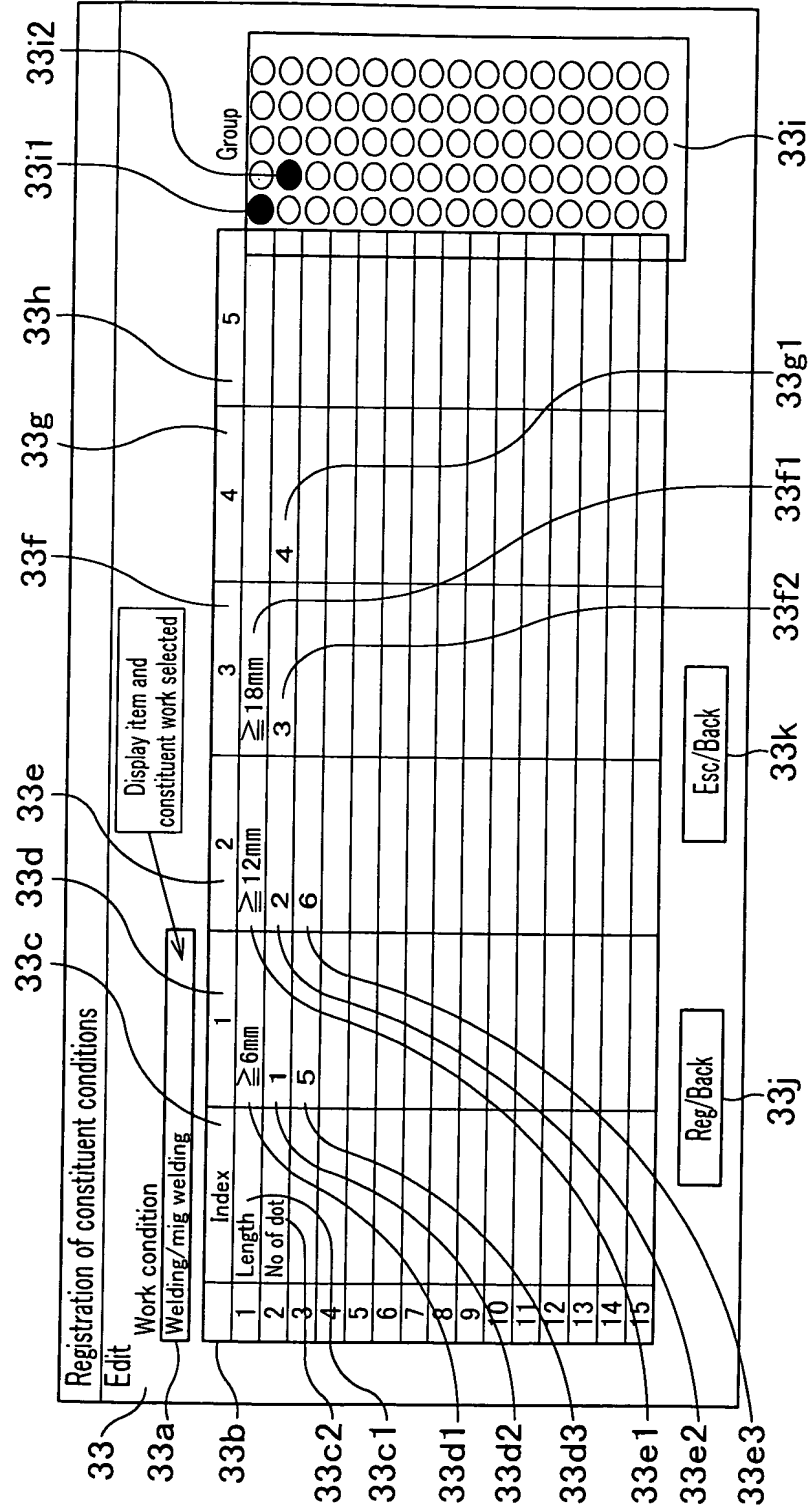




FIG. 7C



18

7

FIG.9A

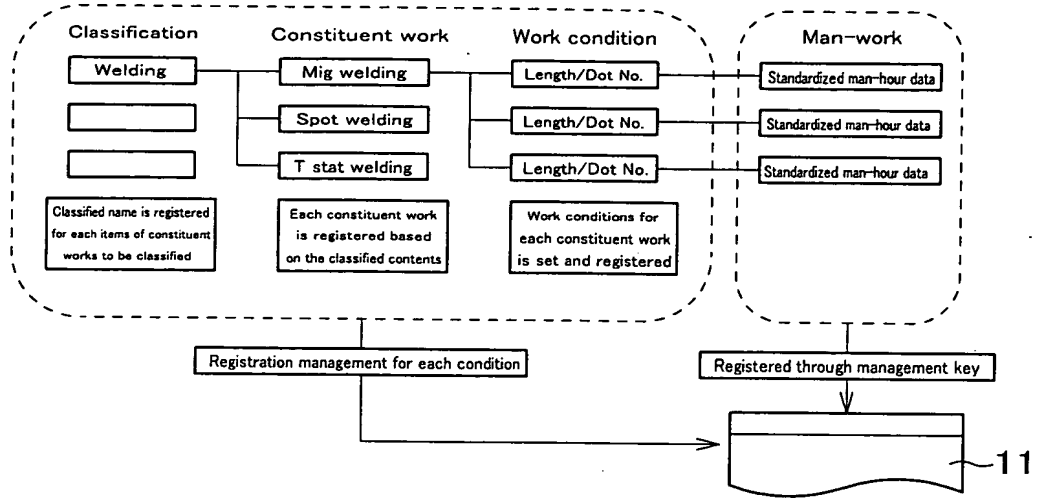


FIG.9B

34d1 34 34d 34e2 34e1 34i 34e

Select item condition of registering stand. man-work

34a Edit

Standardized Man-work Registration

34c1 Class.

- Welding
- Fastening
- Adhering
- Fitting

34c

Constituent work

- Spot welding
- Mig welding
- T stat welding

Setting work cond.

Length ☒ ≥6mm ☐ ≥12mm ☐ ≥18mm

Dot No. ☒ 1 ☐ 2 ☐ 3 ☐ 4

☐ 5 ☐ 6

Display tot. m-work

Display end line of group

34f

Standardized man-work

34g

Remarks

34h

34b

Input standardized man-work data

34b1 34b3 34b5 34b7 34b9 34b11 34b13 34b15 34b17

34b2 34b4 34b6 34b8 34b10 34b12 34b14 34b16

34b18

[12]	[13]	[14]	[15]	[16]	[17]	[18]	[19]	[20]	[24]	[25]	[26]	[27]	[28]	[29]	[36]	[37]
------	------	------	------	------	------	------	------	------	------	------	------	------	------	------	------	------

FIG. 10A

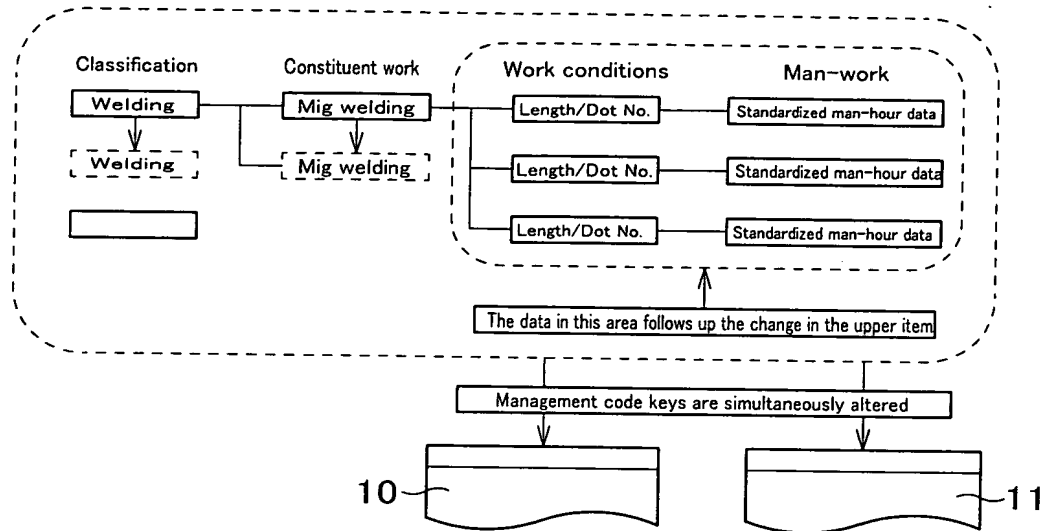


FIG. 10B

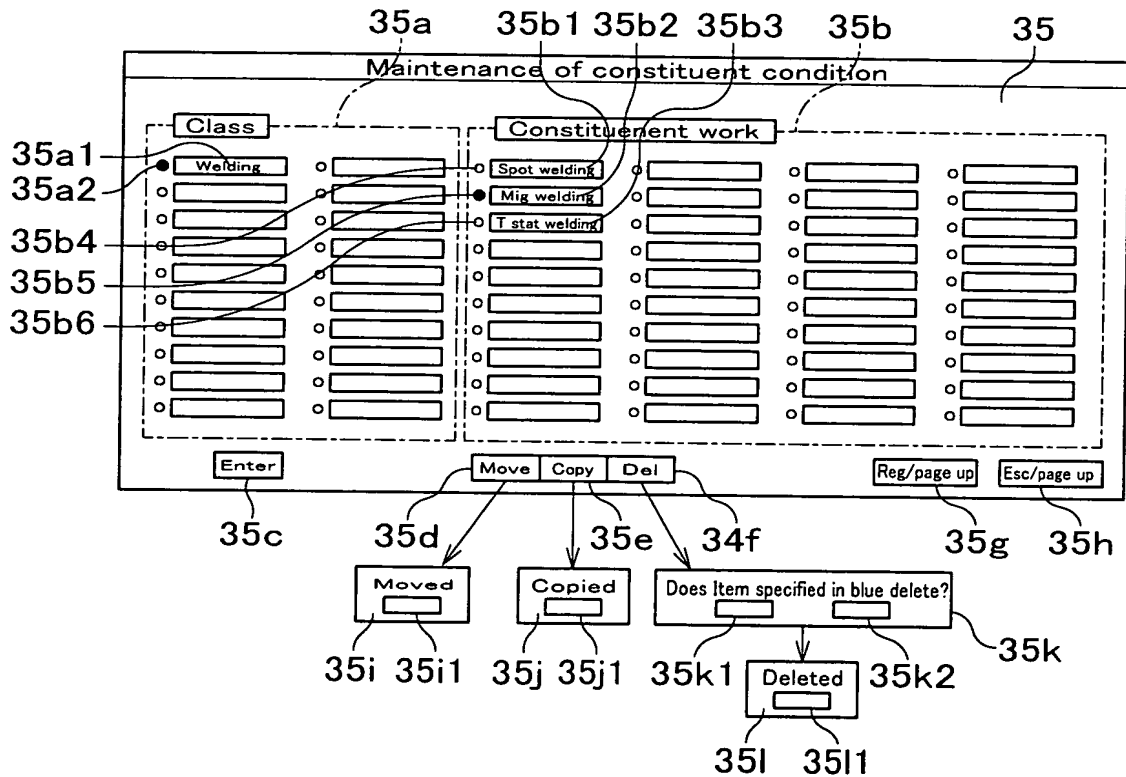


FIG. 11

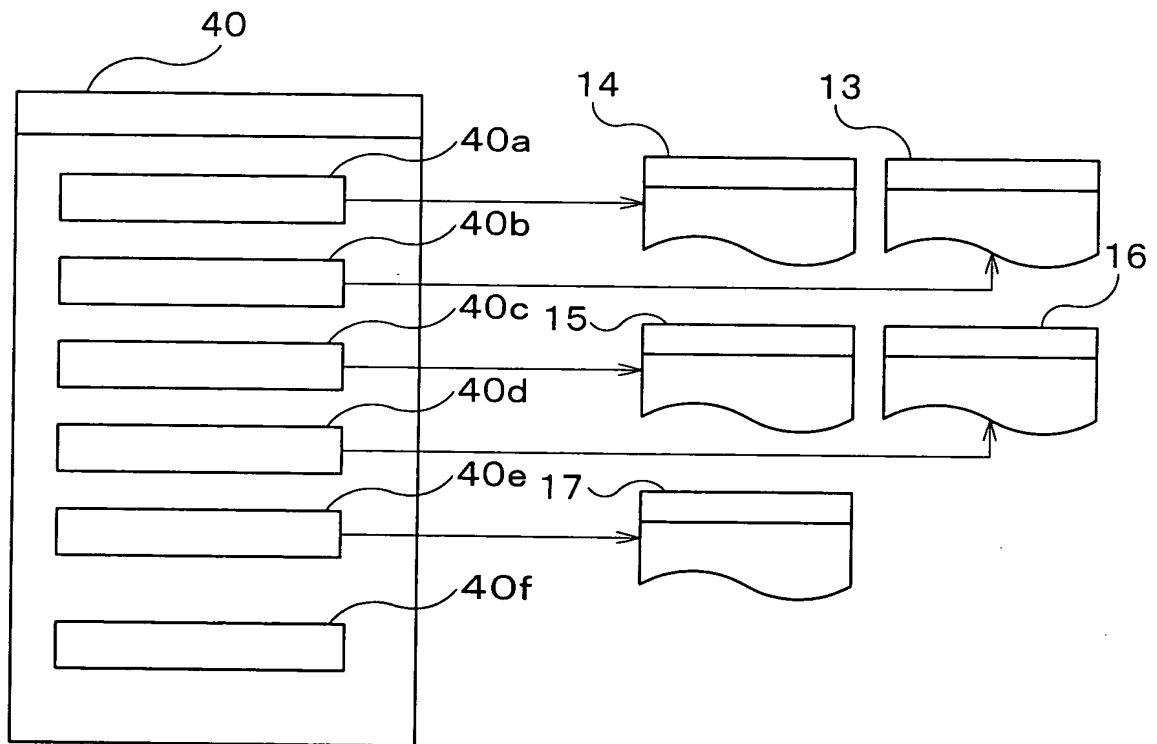


FIG. 11

FIG. 12A

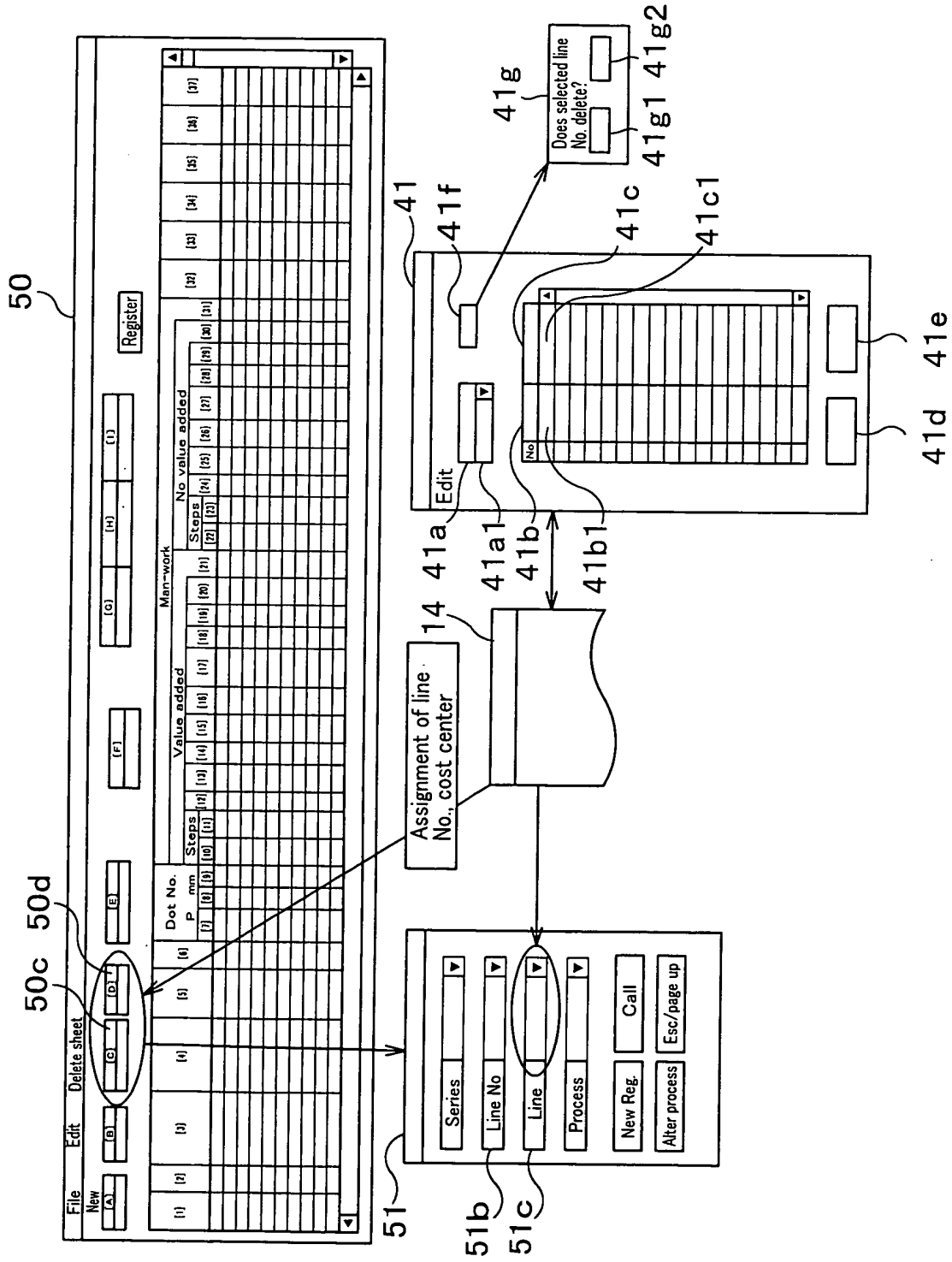




FIG. 12B

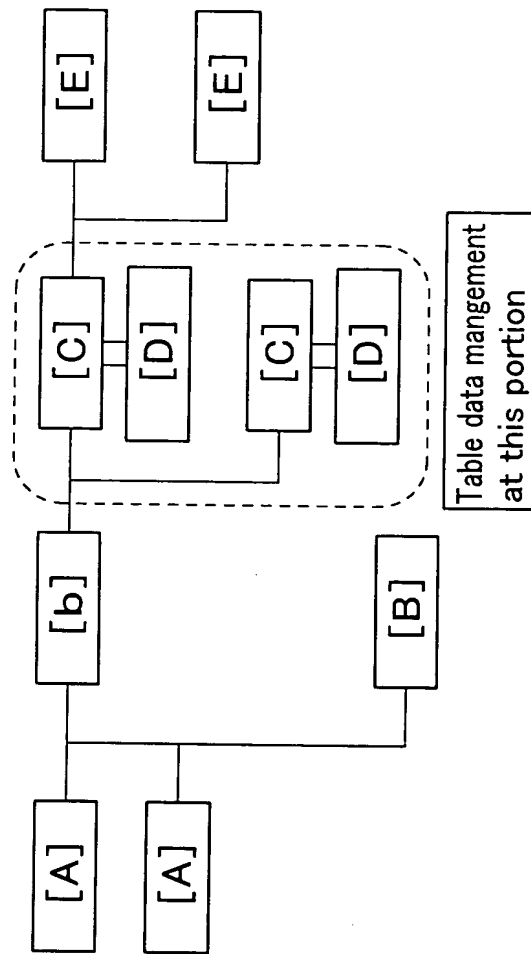




FIG. 14

FIG. 14

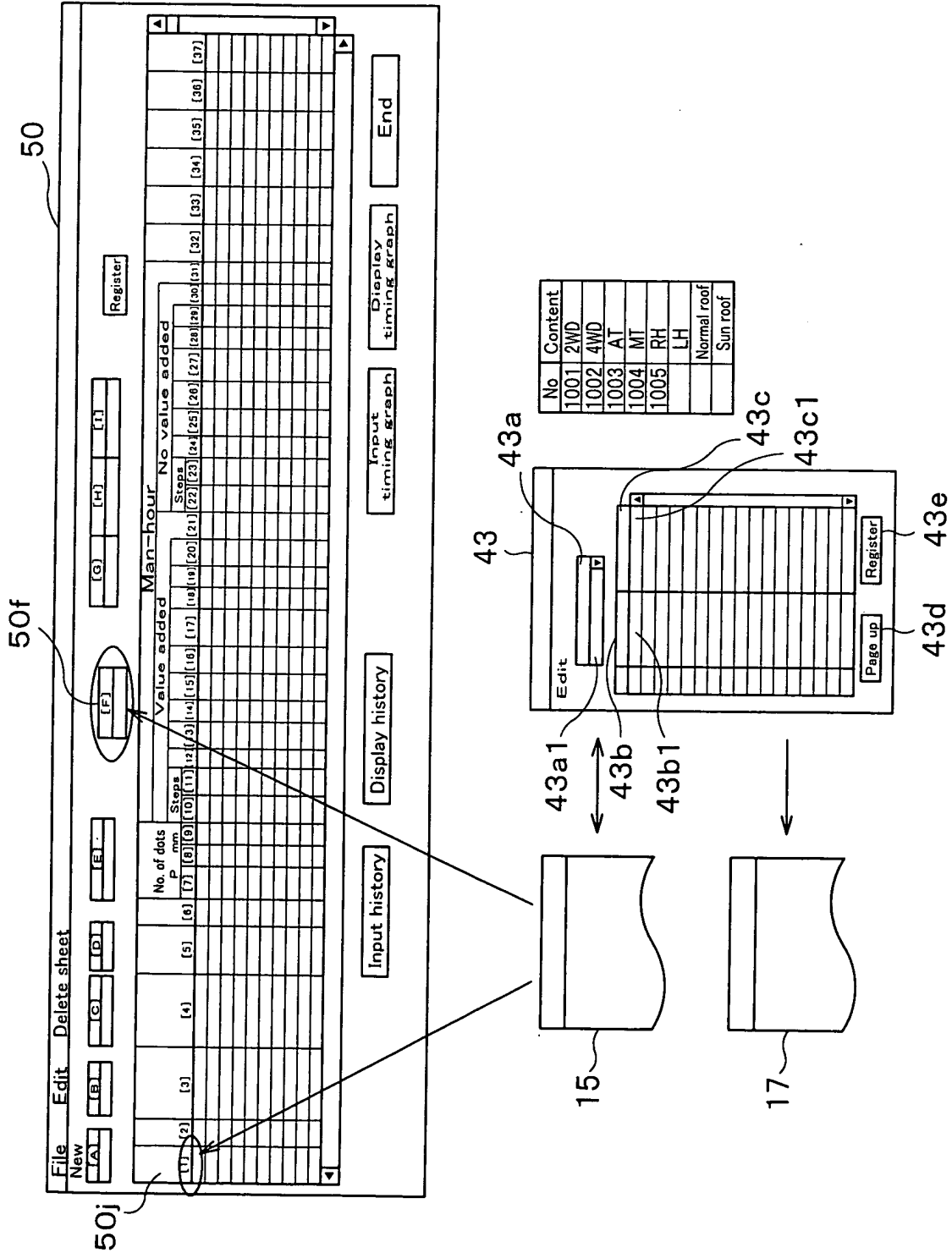


FIG. 15

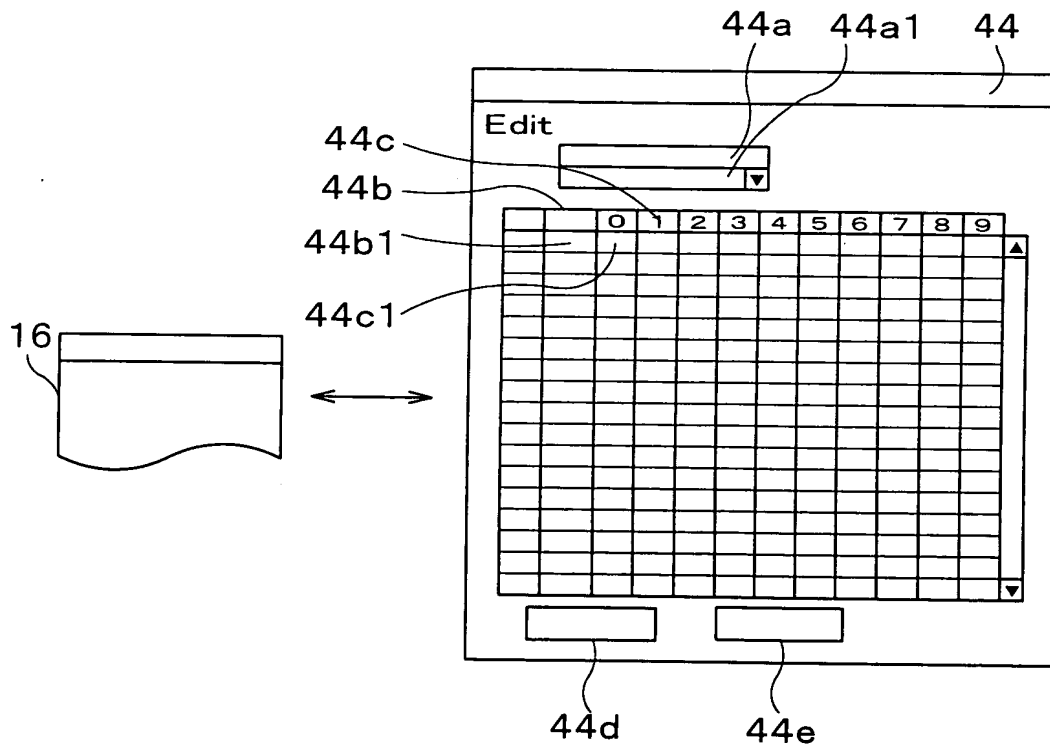
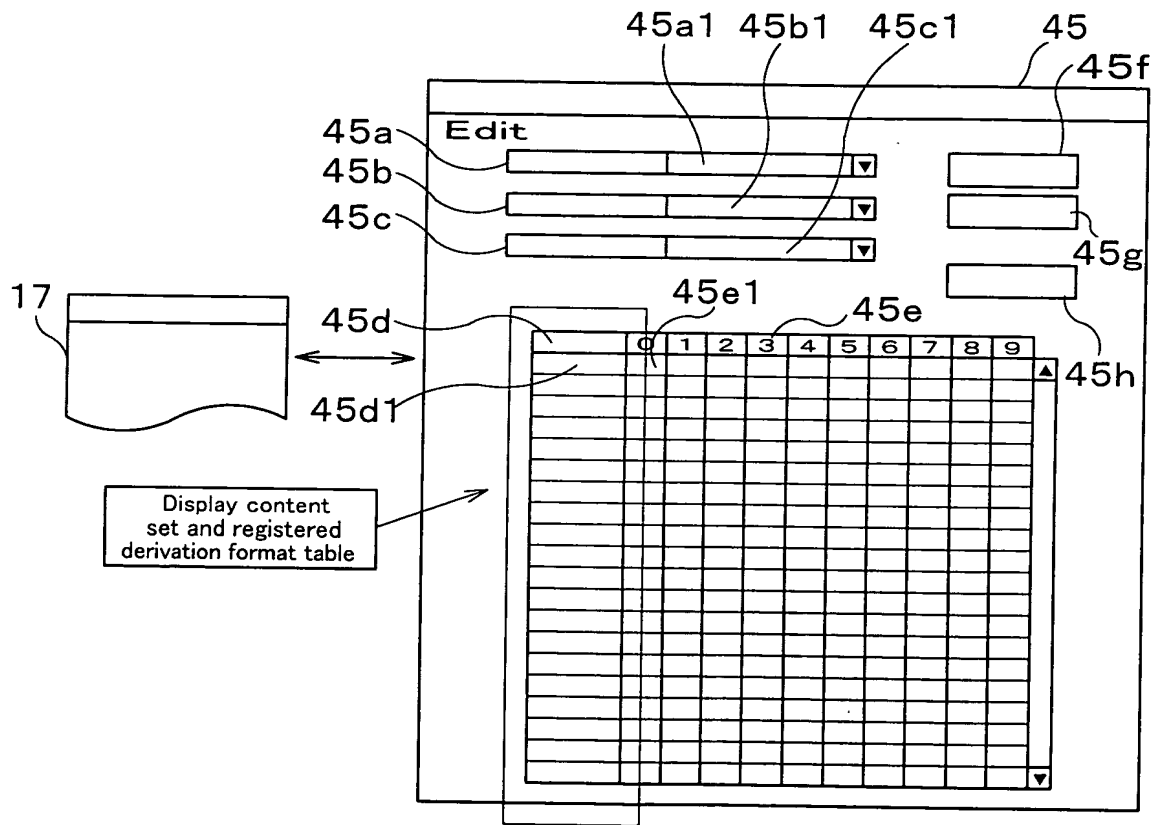


FIG. 16



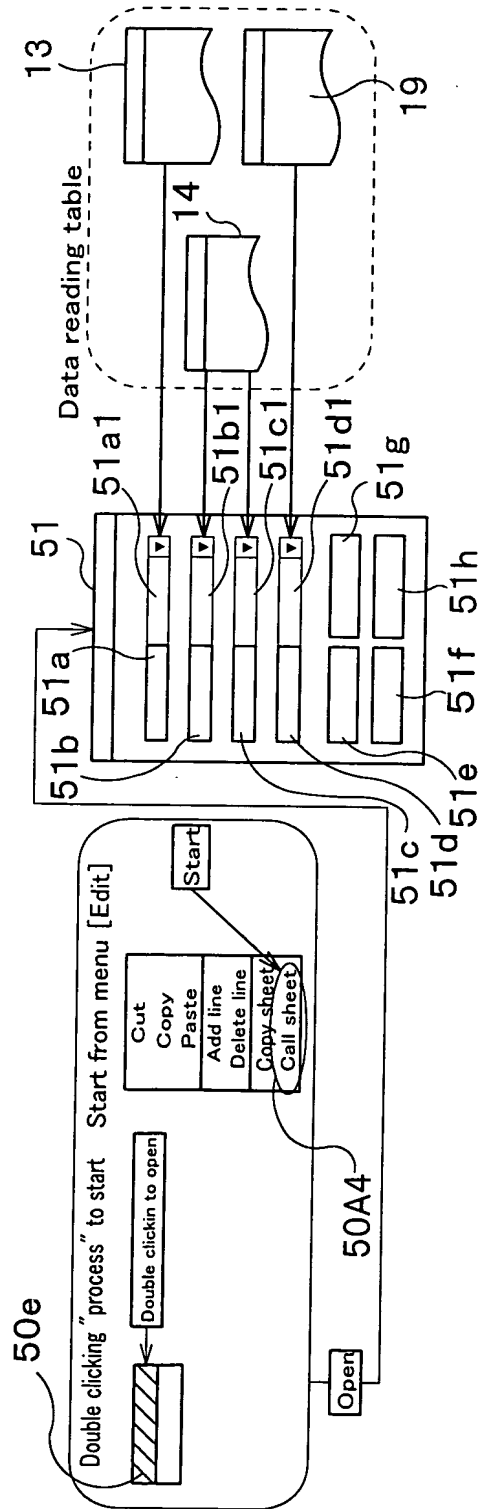
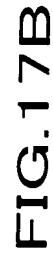


FIG. 18A

FIG. 18A

50f

50j

50k

50j1

50w

File Edit Delete sheet

New

[A] [B] [C] [D] [E] [F] [G] [H] [I] [J]

Register

Man-hour	
No. of dots p. mm	Steps
[1] [2] [3] [4] [5] [6] [7] [8] [9] [10] [11] [12] [13] [14] [15] [16] [17] [18] [19] [20] [21] [22] [23] [24] [25] [26] [27] [28] [29] [30] [31] [32] [33] [34] [35] [36] [37]	

Value added

No value added

Input history

Display history

Input timing graph

Display timing graph

End

FIG. 18B

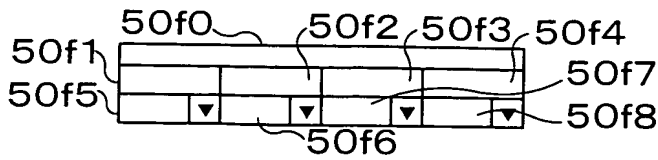


FIG. 18C

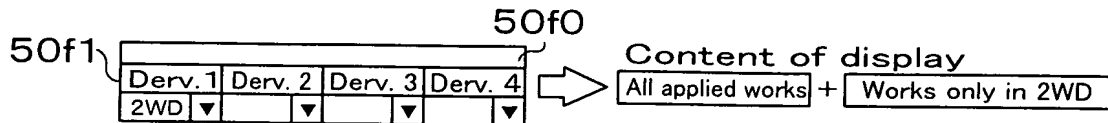


FIG. 18D

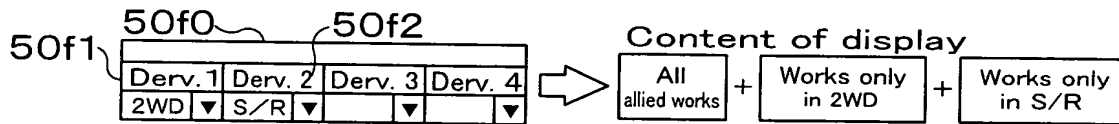


FIG. 18E

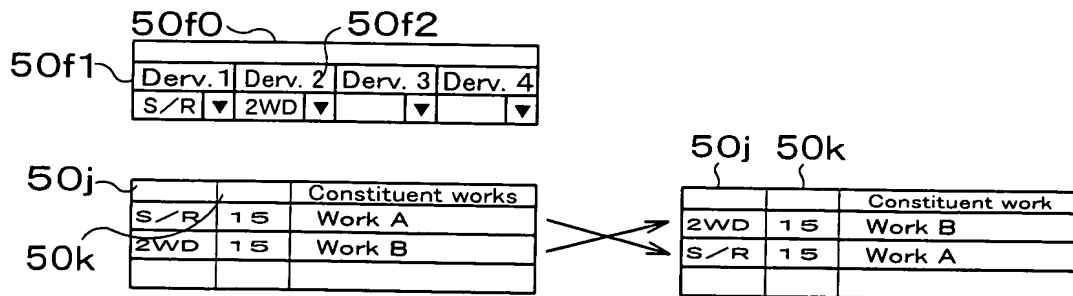


FIG. 18F

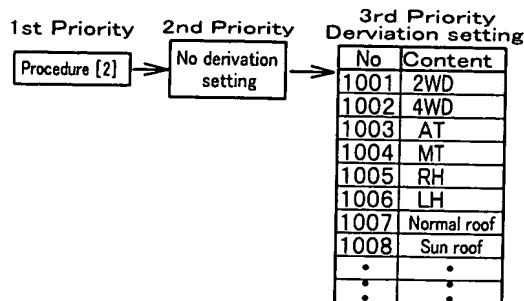
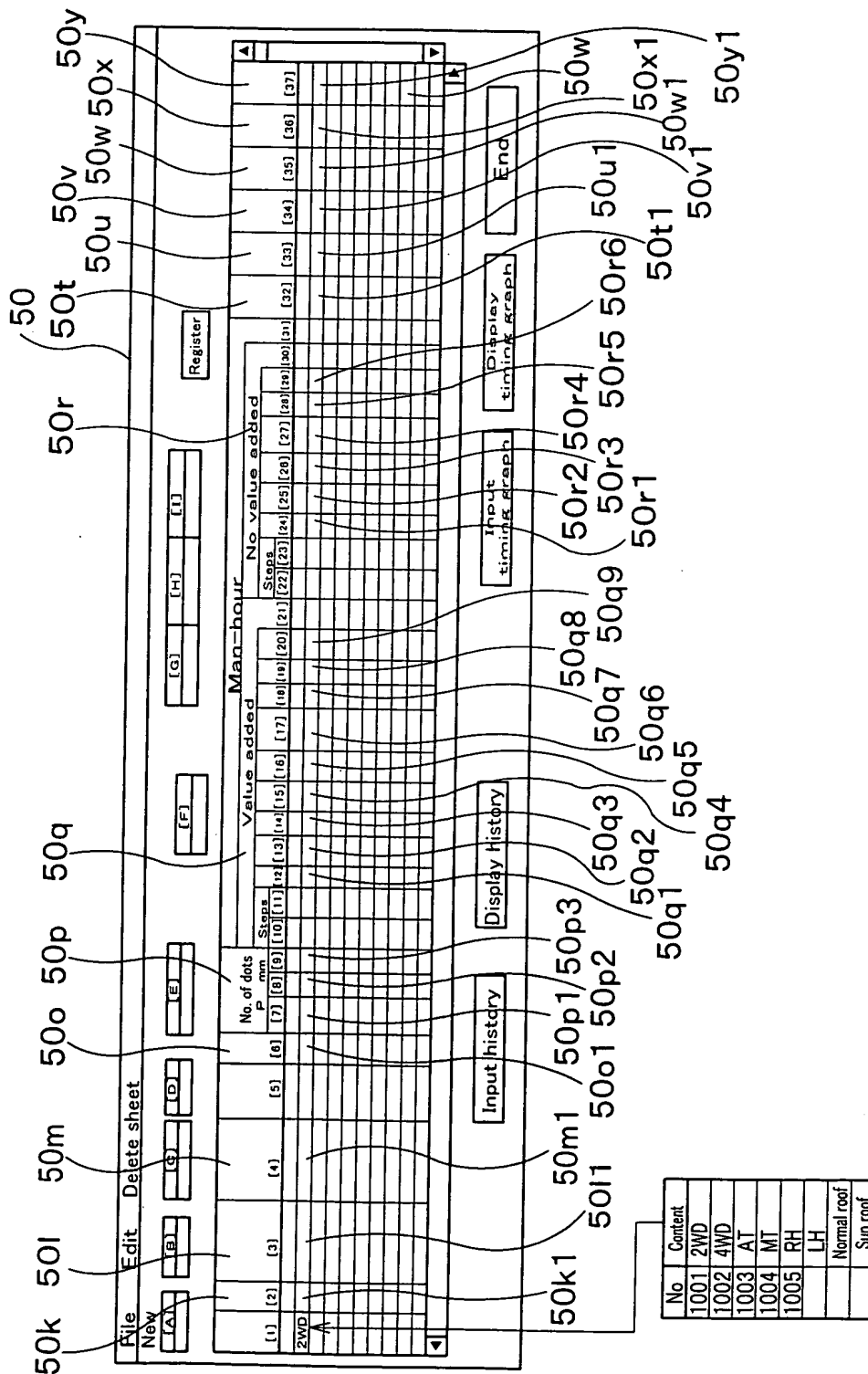
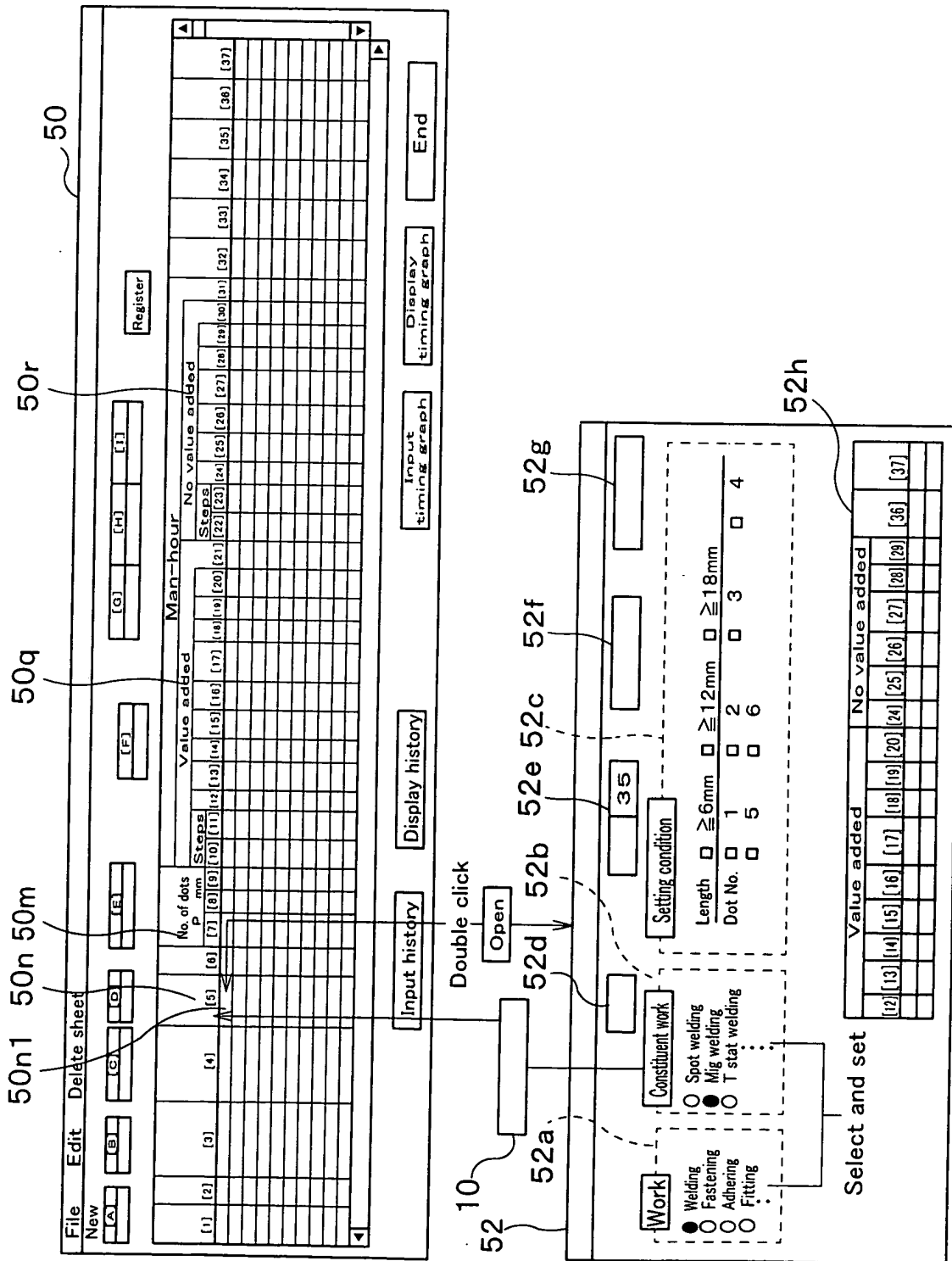




FIG. 19



**FIG. 20**



[illegible]

Write the total of wait [1] ~ [5] on wait [29] of  
main man-work management as a line unit  
\*write at storage of timing data in man works

Processing main data  
Subtotal [30] + [31] is re-calculated  
and is required to be written on DB

FIG. 22

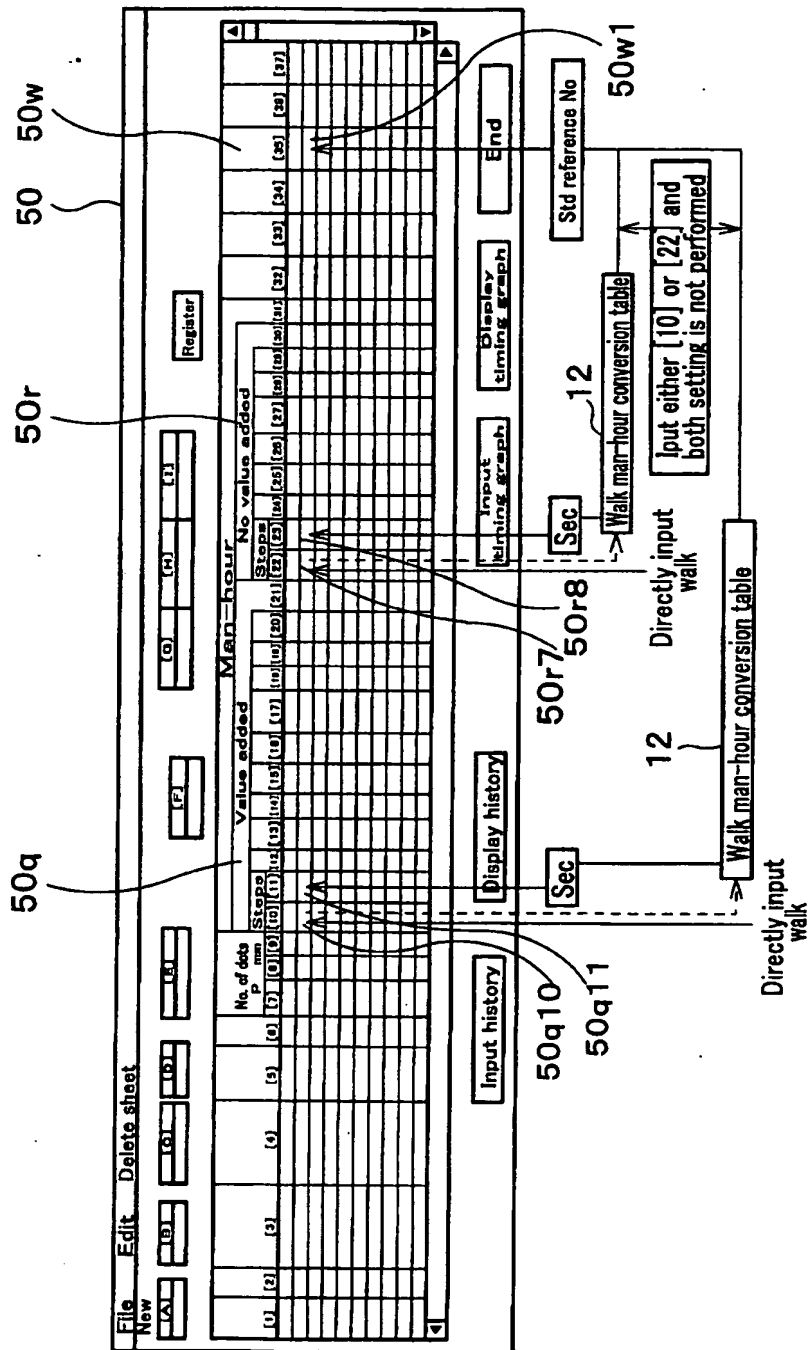


FIG. 23

FIG. 23

50q

50h

50h1

50

50q12

50w

File New Edit Delete sheet

(A) (B) (C) (D) (E) (F)

Proc. per sheet

Register

Total of [H] + [I] in sheet unit

Sub-total of each line [2]

Man-hour

Steps	Value added		No value added	
	[13]	[14]	[21]	[22]
[1]	[13]	[14]	[21]	[22]
[2]	[13]	[14]	[21]	[22]
[3]	[13]	[14]	[21]	[22]
[4]	[13]	[14]	[21]	[22]
[5]	[13]	[14]	[21]	[22]
[6]	[13]	[14]	[21]	[22]
[7]	[13]	[14]	[21]	[22]
[8]	[13]	[14]	[21]	[22]
[9]	[13]	[14]	[21]	[22]
[10]	[13]	[14]	[21]	[22]
[11]	[13]	[14]	[21]	[22]
[12]	[13]	[14]	[21]	[22]
[13]	[13]	[14]	[21]	[22]
[14]	[13]	[14]	[21]	[22]
[15]	[13]	[14]	[21]	[22]
[16]	[13]	[14]	[21]	[22]
[17]	[13]	[14]	[21]	[22]
[18]	[13]	[14]	[21]	[22]
[19]	[13]	[14]	[21]	[22]
[20]	[13]	[14]	[21]	[22]
[21]	[13]	[14]	[21]	[22]
[22]	[13]	[14]	[21]	[22]
[23]	[13]	[14]	[21]	[22]
[24]	[13]	[14]	[21]	[22]
[25]	[13]	[14]	[21]	[22]
[26]	[13]	[14]	[21]	[22]
[27]	[13]	[14]	[21]	[22]
[28]	[13]	[14]	[21]	[22]
[29]	[13]	[14]	[21]	[22]
[30]	[13]	[14]	[21]	[22]
[31]	[13]	[14]	[21]	[22]
[32]	[13]	[14]	[21]	[22]
[33]	[13]	[14]	[21]	[22]
[34]	[13]	[14]	[21]	[22]
[35]	[13]	[14]	[21]	[22]
[36]	[13]	[14]	[21]	[22]
[37]	[13]	[14]	[21]	[22]

Input history

Display history

Input timing graph

Display timing graph

End

Total of [11] - [20] per line

Total of each line subtotals [21] + [30]



[illegible]

FIG. 26

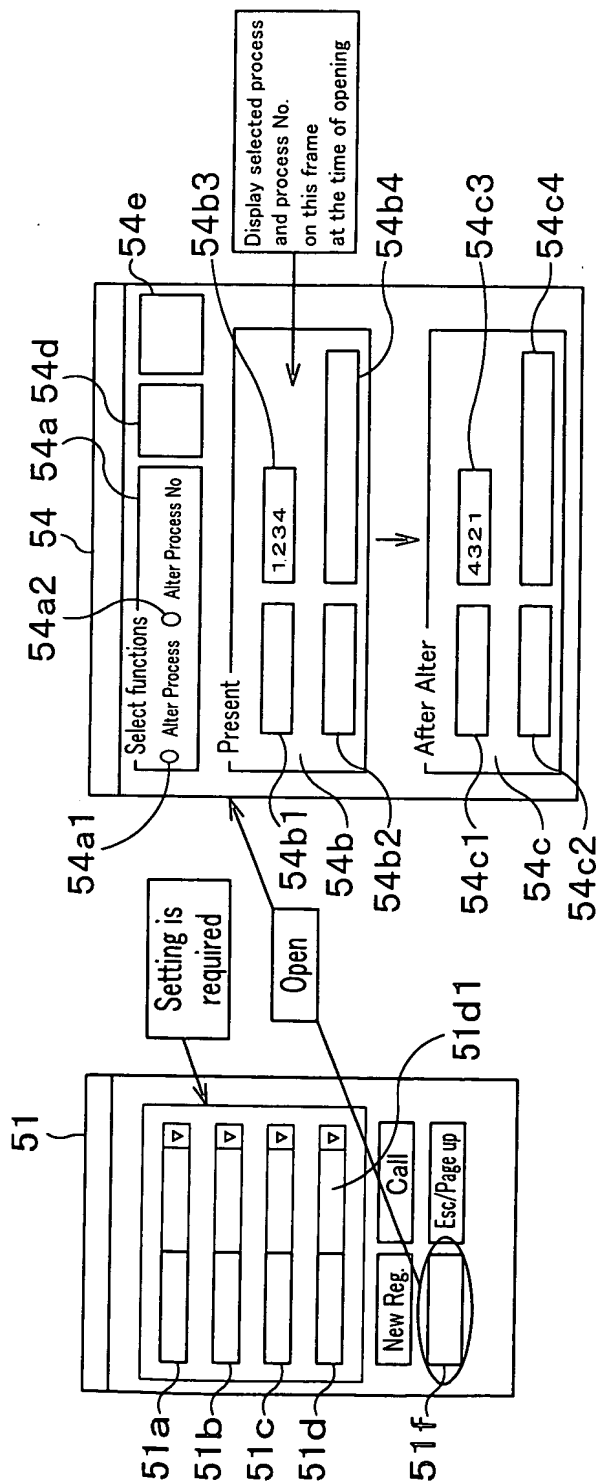
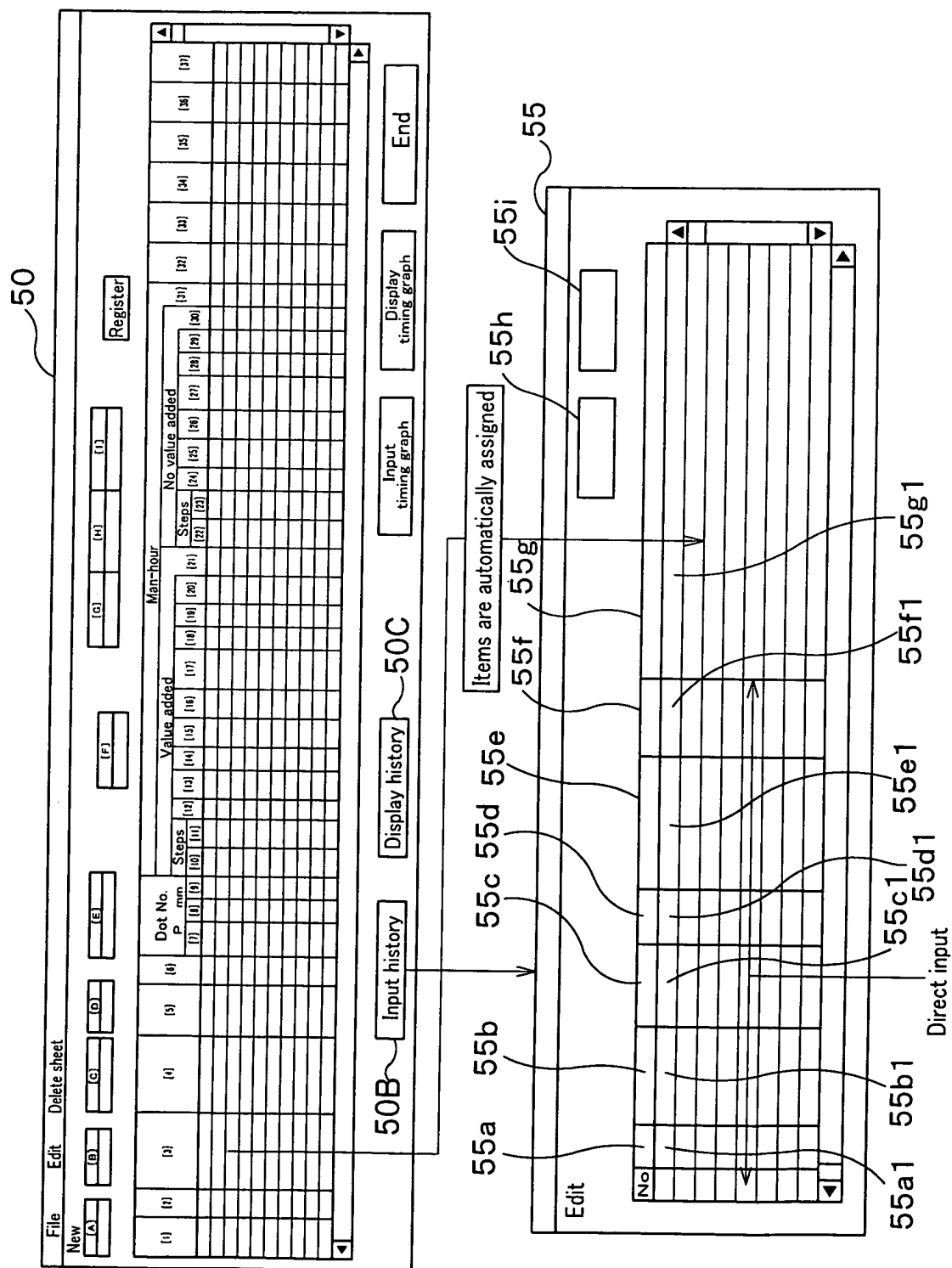




FIG. 27



**FIG. 28**

FIG.29A

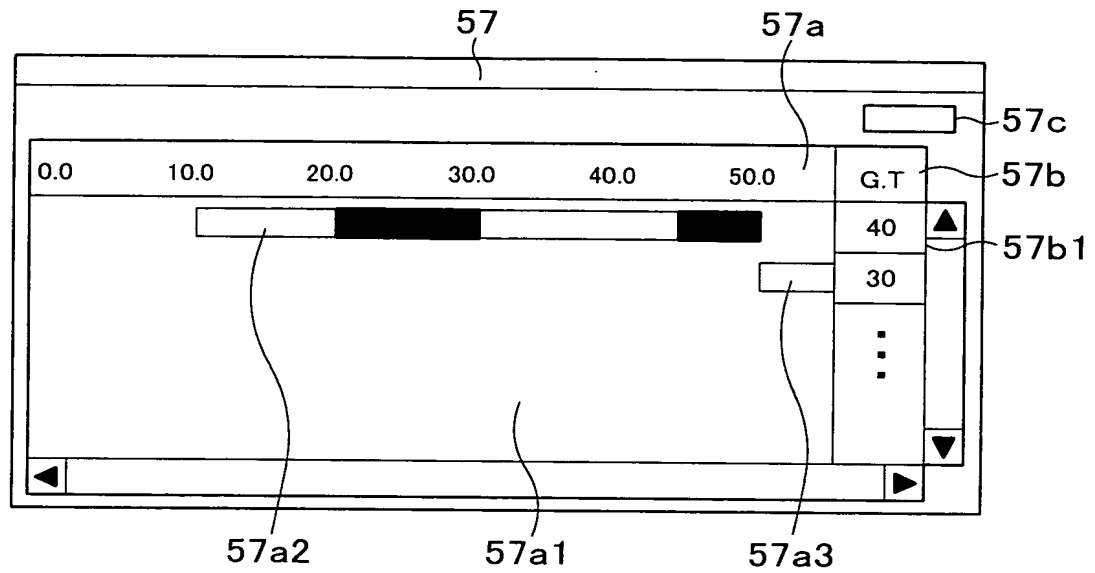
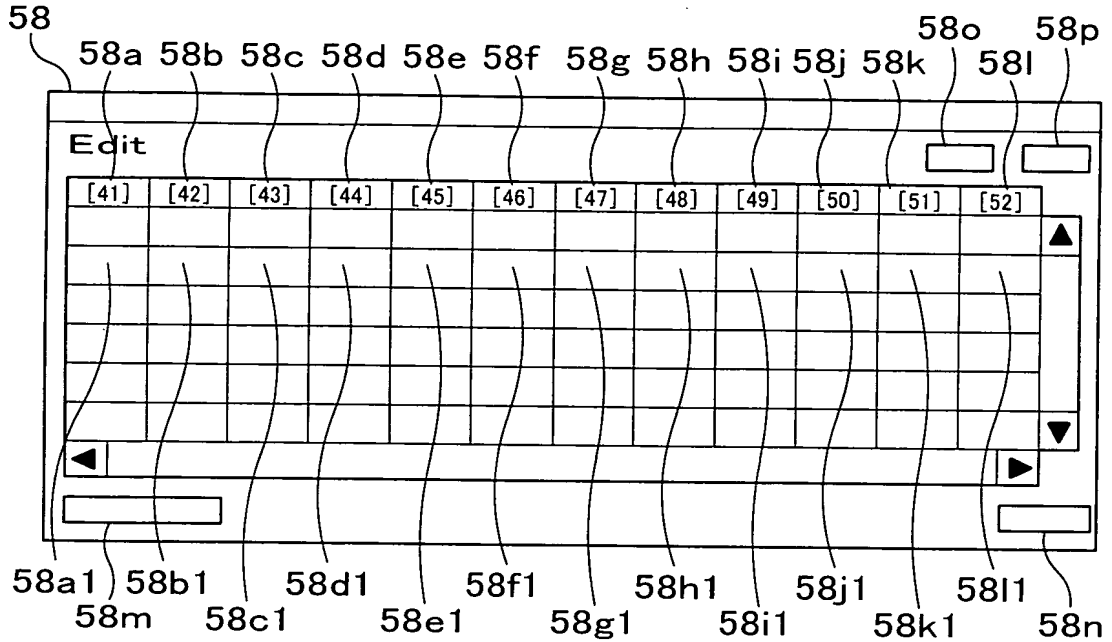


FIG. 29B



**FIG. 30**

Figure 1 is a schematic diagram of a computer system 50. The system includes a File menu with options Edit, Delete sheet, and New. Below the menu are input fields for file names (A, B, C, D, E, F, G, H, I) and a Register button. The main window is divided into three sections: 50G (Input history), 50D (Display history), and 50W (Input timing graph). The 50G section contains a table with columns for No. of dots, P, mm, Steps, Value added, and No value added. The 50D section contains a table with columns for S.T, Wait 1, Wait 2, Wait 3, Wait 4, Wait 5, and Total. The 50W section contains a table with columns for S.T, Wait 1, Wait 2, Wait 3, Wait 4, Wait 5, and Total. The 50W section also includes a Page up button and a Total button.

**SECRET**

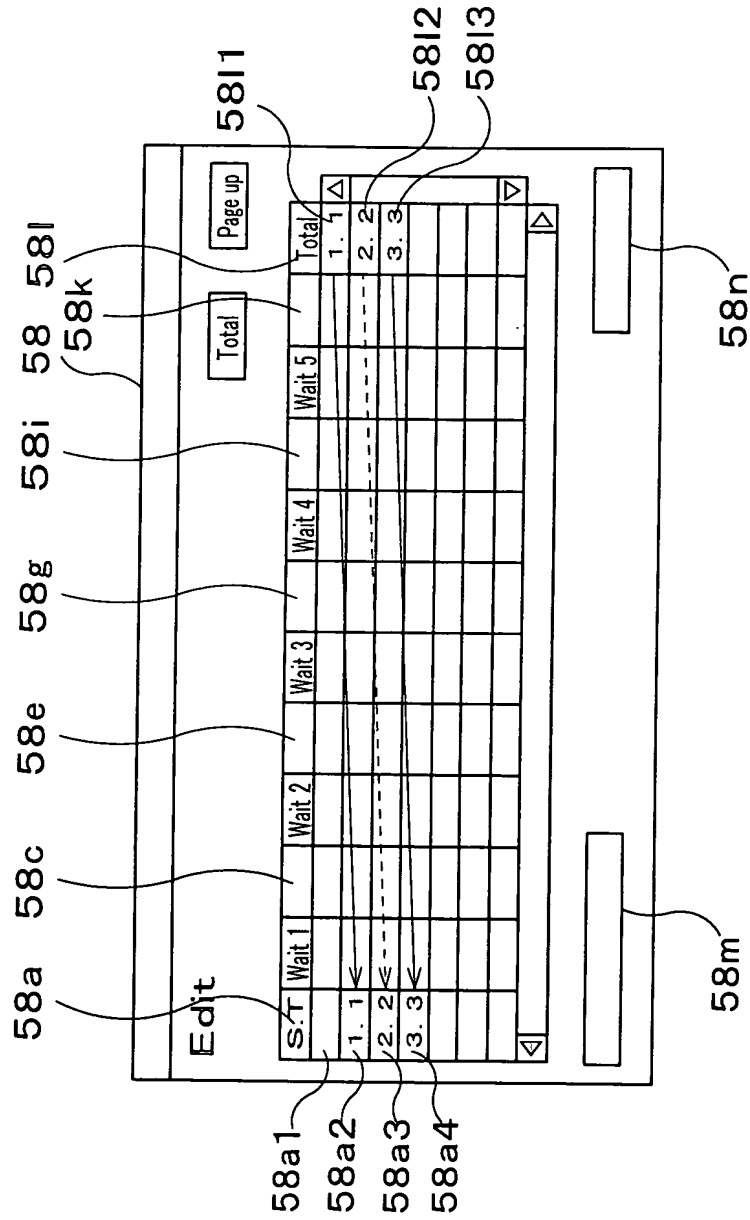
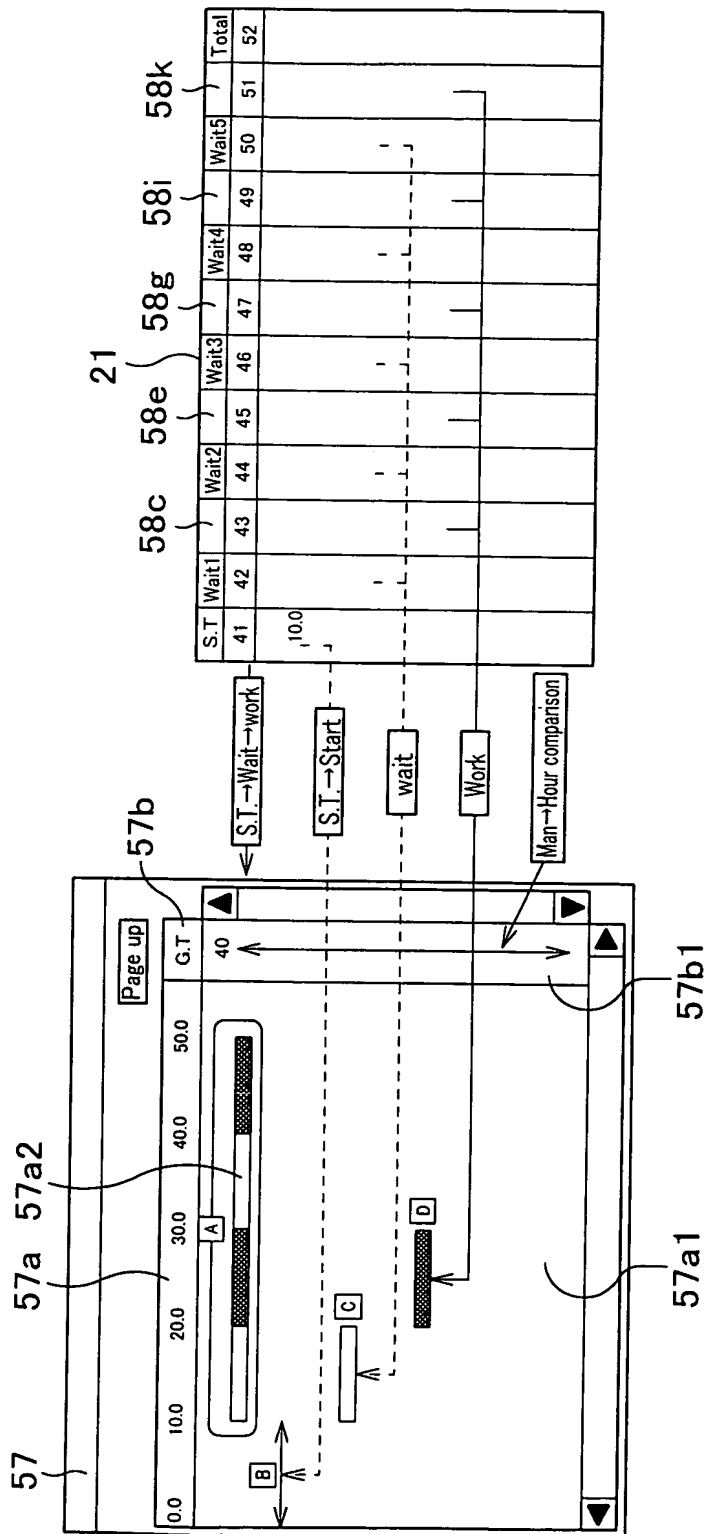


FIG. 32



FD 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100

FIG.33A

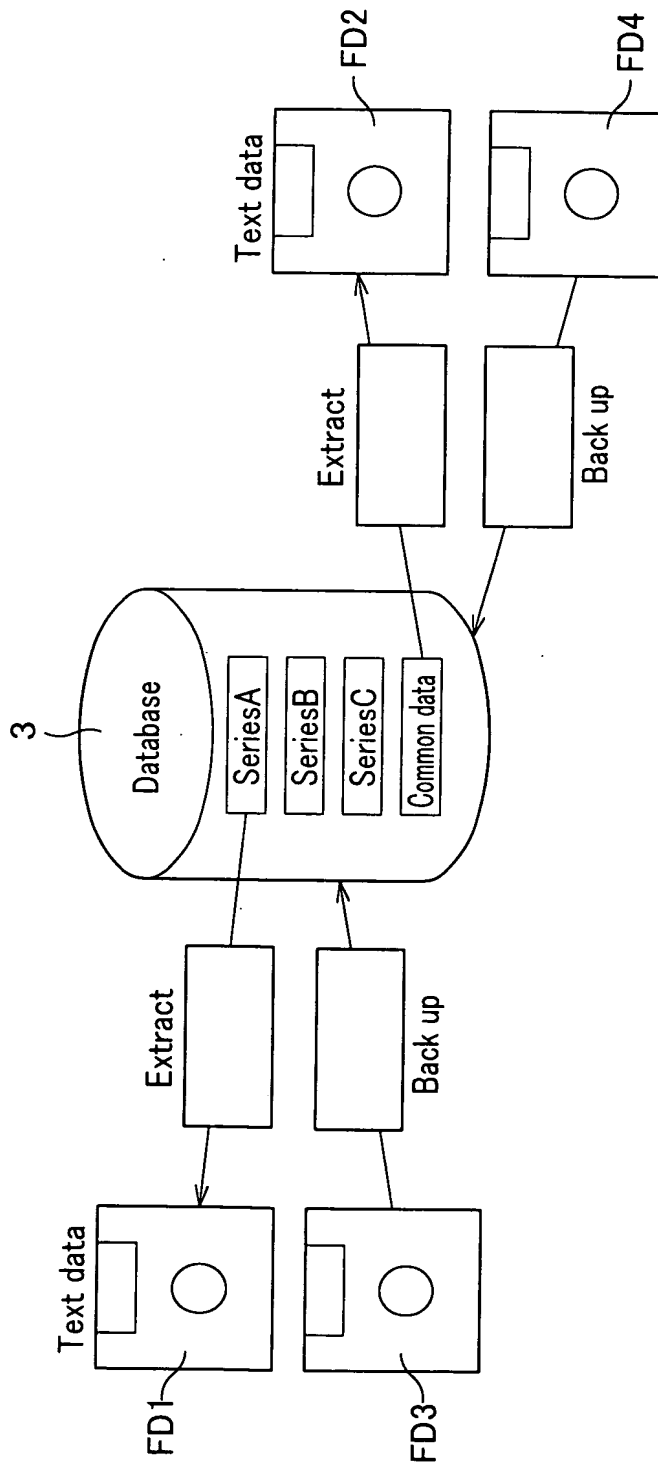




FIG. 33B

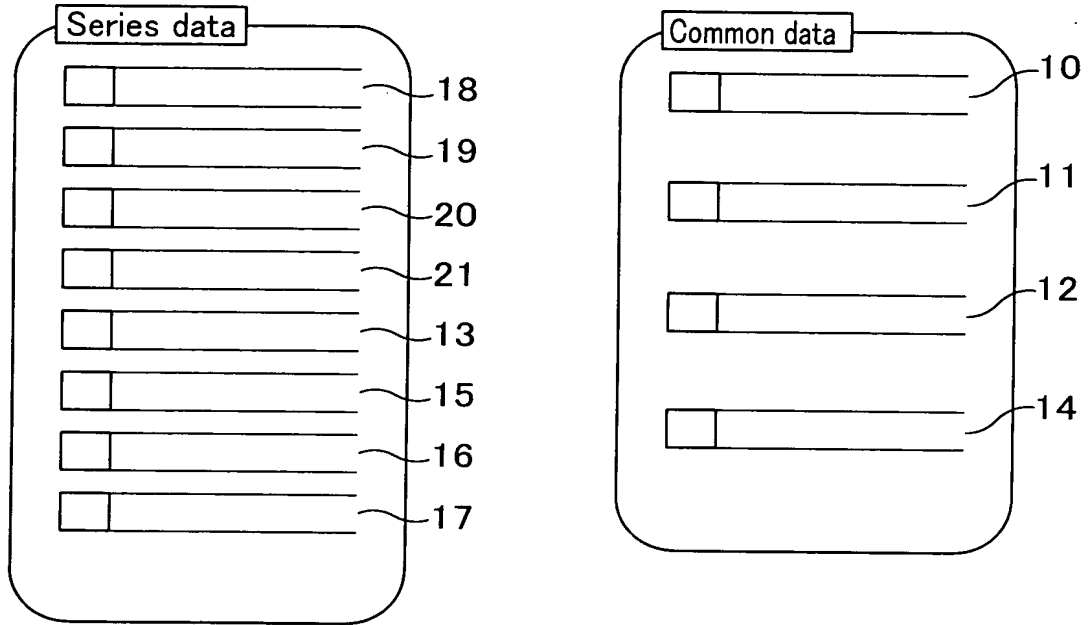


FIG. 34

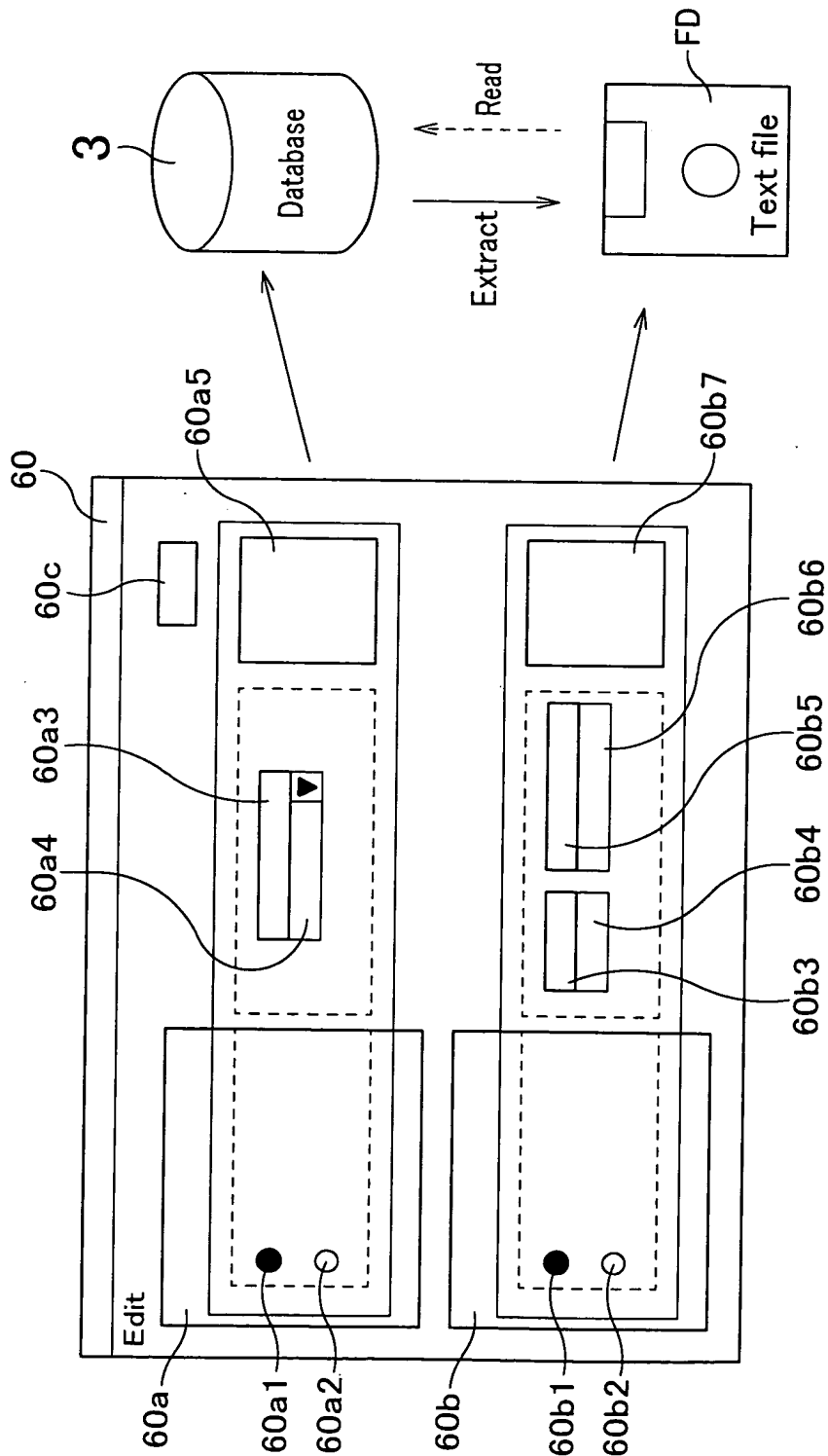
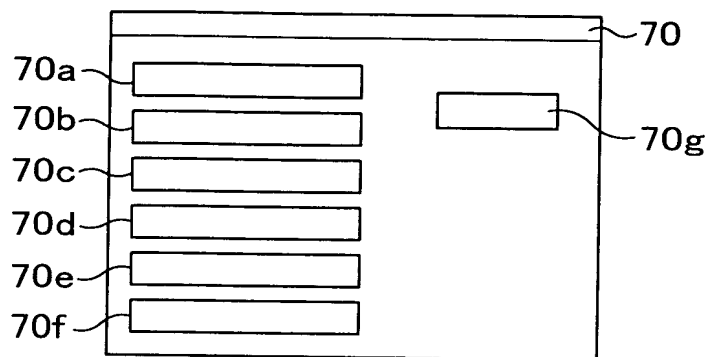


FIG. 35



09342472.042601

FIG. 36

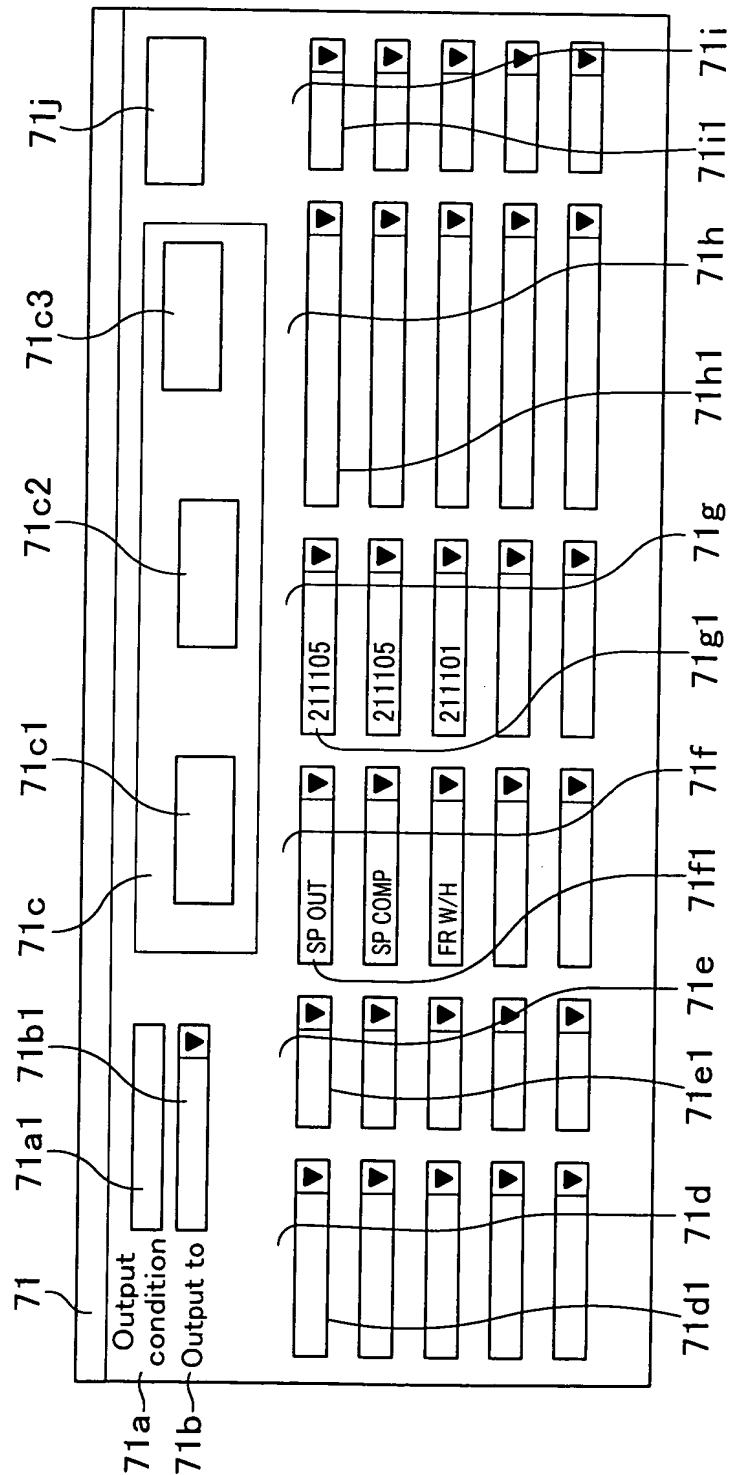


FIG.37A

72 72a 72a1 72b1 72b 72d

Seriese	No condition				
Line NO.	No condition				
Line name	SP OUT	SP COMP	FR W/H		
Cost sensor	211105	211105	211101		
Process	No condition				
Derivation	No condition				

1	FR W/H	211101	SET LH	1	Side frame		Off	▲
2				2	Side frame		Out	
3				3	Side frame		Turn	
4				4	Side frame	T.T M/C	Set	
5				5	Clamper		Push button	
6				6	Dumper housing		Off	
7				7	Dumper housing		Out	▼

72c

FIG. 37B

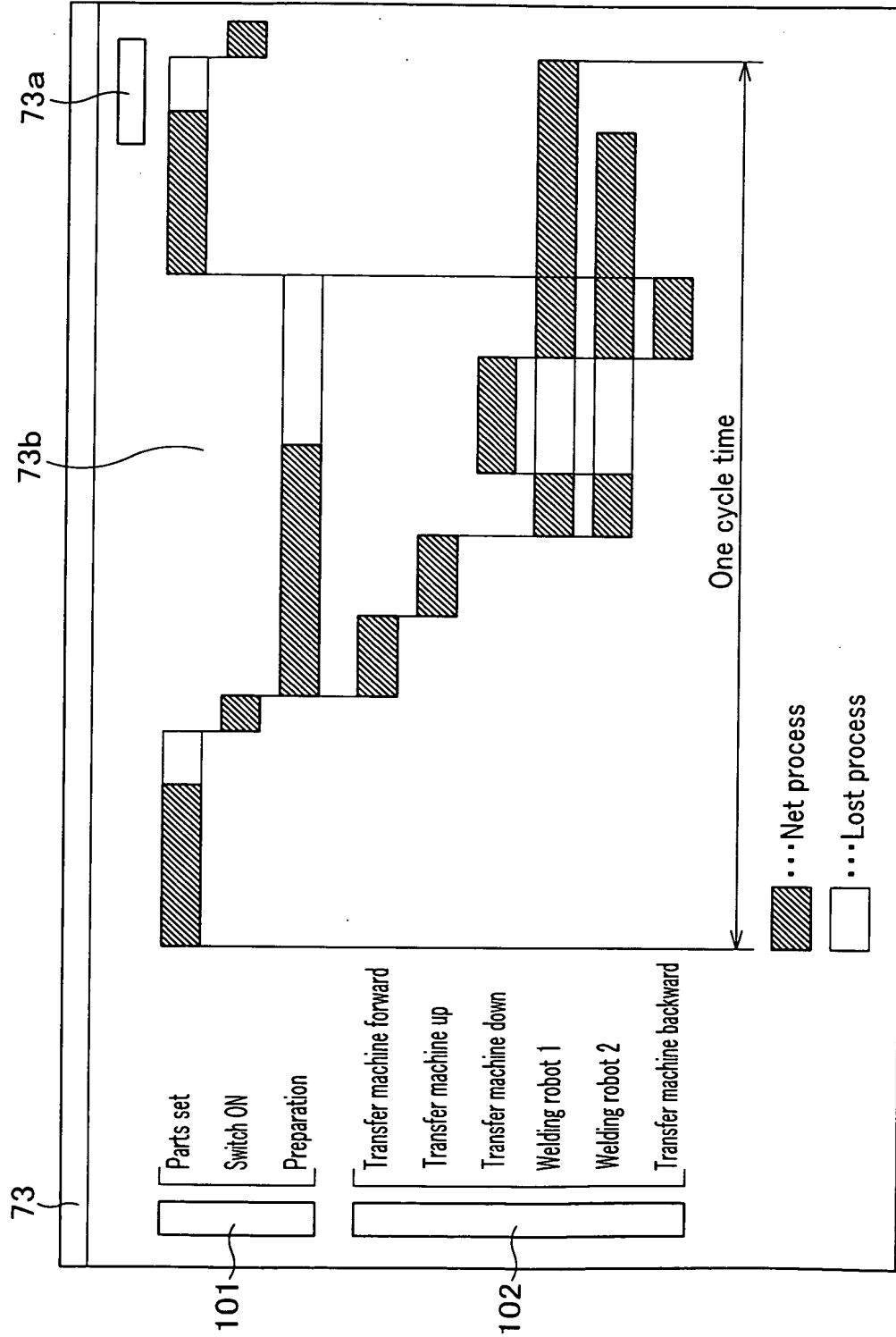
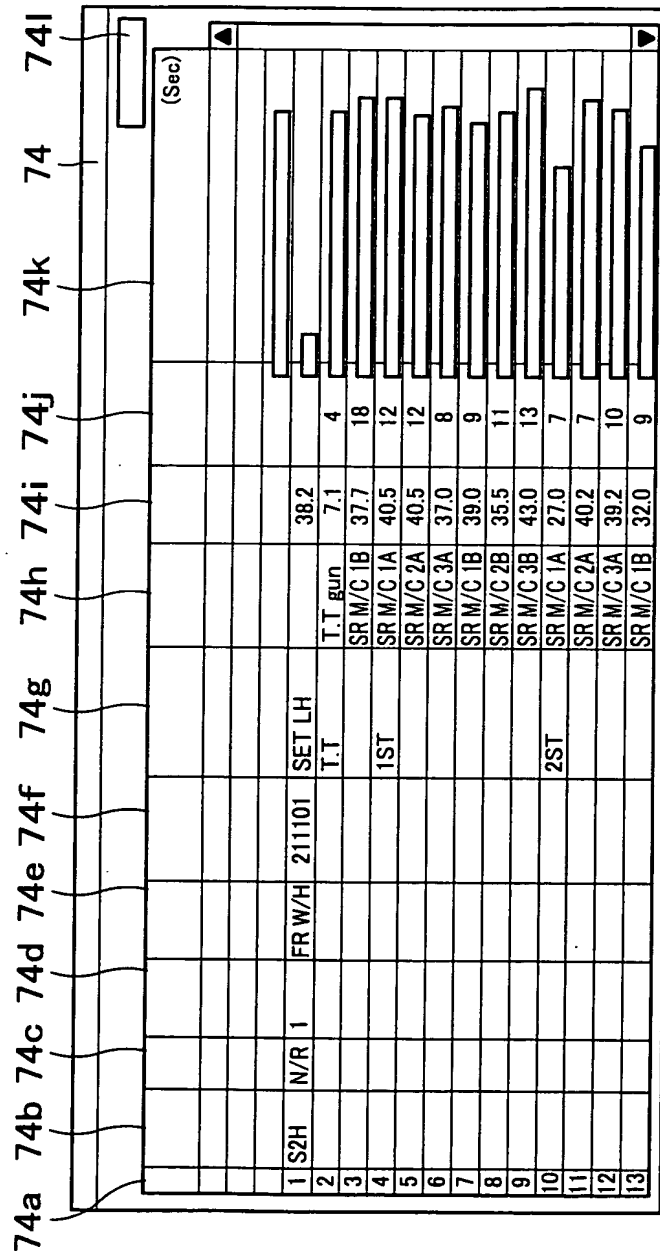


FIG. 38

FIG. 38



75a 75b 75c 75d 75e 75f 75g 75h 75i 75j 75k 75l 75m 75n 75o 75p

75r1 75r1

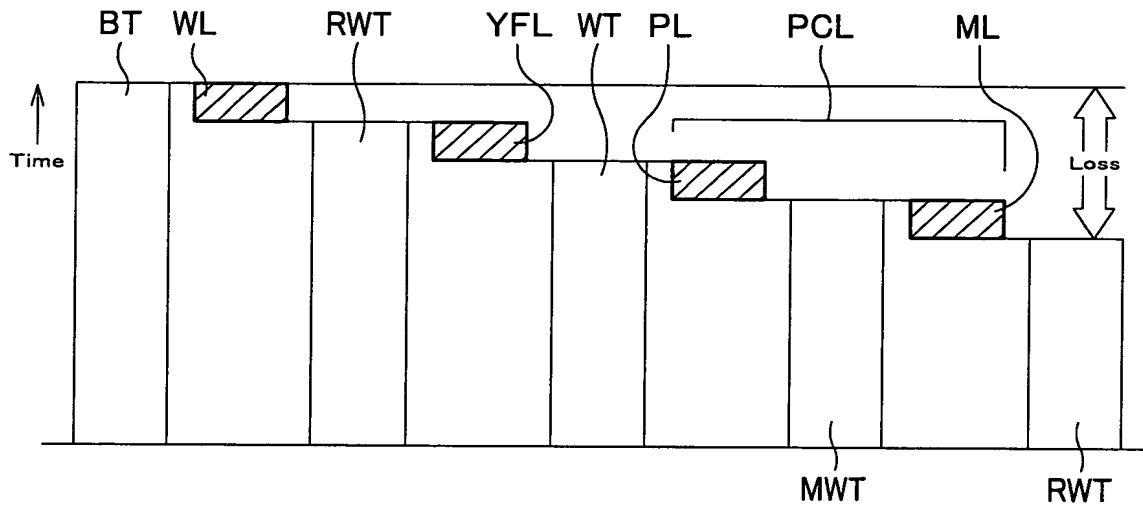


FIG. 40

76a	76b	76c	76d	76e	76f	76g	76h	76i	76j	76k	76l	76m	76
1 S2H	N/R	1	FR W/H	211101	T.T	T.T gun		Set	4				
2						SRM/C 1B		Set	18				
3					1ST	SRM/C 1A		Set	12				
4						SRM/C 2A		Set	12				
5						SRM/C 3A		Set	8				
6						SRM/C 1B		Set	9				
7						SRM/C 2B		Set	11				
8						SRM/C 3B		Set	13				
9					2ST	SRM/C 1A		Set	7				
10						SRM/C 2A		Set	7				
11						SRM/C 3A		Set	10				
12						SRM/C 1B		Set	9				
13						SRM/C 2B		Set	14				
14						SRM/C 3B		Set	12				
15					Sub Total				146				
16													

Figure 1 is a schematic diagram of a data entry interface. It features a main rectangular area with a grid of input fields. The grid is organized into rows and columns, with labels on the left side: "Series", "Line No", "Line", "Cont sensor", "Process", and "Derivation". Each row has six input fields. Some fields contain text: "No condition", "SP OUT", "211105", "SP COMP", "211101", "FR W/H". To the right of the main grid is a vertical column of input fields, with labels "77a", "77a1", "77b1", "77b", and "77e" pointing to specific fields. Below the main grid is a table with 7 rows and 7 columns. The table headers are "Class", "Change No", "Date", "Editor", "Content", "Changed", "Series", "Content", "LineNo", "Line", and "No". The table contains data for 7 rows, with the first row having values: "1", "- E 1", "S24A-F-0001", "1998/8/25", "812563", "Process reduction by spec. change", "-2.60", "S2H", "N/R", "1", "FR W/H", "2". The table is flanked by a vertical bar on the left and a vertical bar on the right, with labels "77c" and "77d" pointing to them respectively.

FIG.42A



09342472, 042601

FIG. 42B

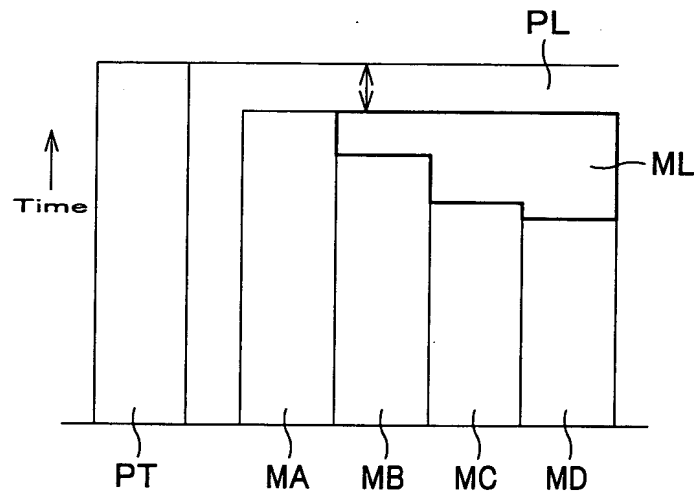


FIG. 43

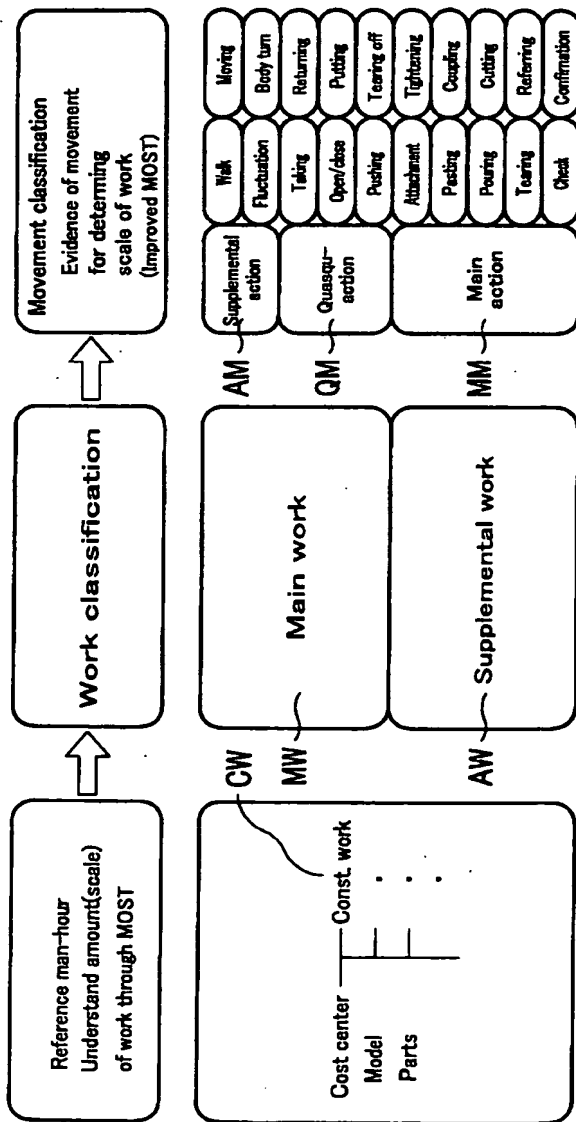
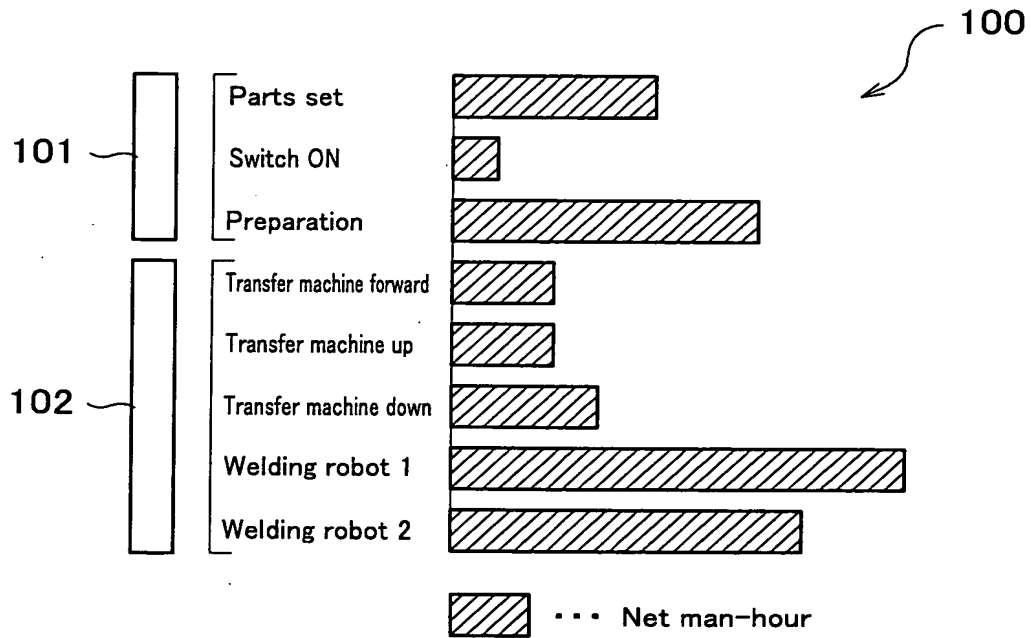


FIG.44



03642473.042601